

(19) World Intellectual Property
Organization
International Bureau



(43) International Publication Date
22 July 2004 (22.07.2004)

PCT

(10) International Publication Number
WO 2004/060990 A2

(51) International Patent Classification⁷: **C08K 5/00**

(21) International Application Number:
PCT/US2003/039314

(22) International Filing Date:
10 December 2003 (10.12.2003)

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data:
60/435,584 20 December 2002 (20.12.2002) US
10/706,669 12 November 2003 (12.11.2003) US

(71) Applicant: **EASTMAN CHEMICAL COMPANY**
[US/US]; 100 North Eastman Road, Kingsport, TN 37660
(US).

(72) Inventors: **STRAND, Marc, Alan**; 5123 Waterford Drive,
Kingsport, TN 37664 (US). **PINER, Rodney, Layne**; 212
Hidden Acres Road, Kingsport, TN 37664 (US).

(74) Agent: **MIDDLEMAS, Eric, D.**; P.O. Box 511,
Kingsport, TN 37662-5075 (US).

(81) Designated States (*national*): AE, AG, AL, AM, AT, AU,
AZ, BA, BB, BG, BR, BW, BY, BZ, CA, CH, CN, CO, CR,
CU, CZ, DE, DK, DM, DZ, EC, EE, EG, ES, FI, GB, GD,
GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR,
KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN,
MW, MX, MZ, NI, NO, NZ, OM, PG, PH, PL, PT, RO, RU,
SC, SD, SE, SG, SK, SL, SY, TJ, TM, TN, TR, TT, TZ, UA,
UG, UZ, VC, VN, YU, ZA, ZM, ZW.

(84) Designated States (*regional*): ARIPO patent (BW, GH,
GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZM, ZW),
Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM),
European patent (AT, BE, BG, CH, CY, CZ, DE, DK, EE,
ES, FI, FR, GB, GR, HU, IE, IT, LU, MC, NL, PT, RO, SE,
SI, SK, TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA,
GN, GQ, GW, ML, MR, NE, SN, TD, TG).

Published:

— *without international search report and to be republished
upon receipt of that report*

*For two-letter codes and other abbreviations, refer to the "Guid-
ance Notes on Codes and Abbreviations" appearing at the begin-
ning of each regular issue of the PCT Gazette.*

(54) Title: **FLAME RETARDANT POLYESTER COMPOSITIONS FOR CALENDERING**

(57) Abstract: Flame retardant polyester compositions suitable for calendering may be prepared from polyesters having crystalliza-
tion half time of at least 5 minutes, a plasticizer, a phosphorus-containing flame retardant miscible with the plasticized polyester,
and an additive effective to prevent sticking of the polyester to the calendar rolls. Also disclosed are processes for flame retardant
films or sheets by calendering the above compositions and the flame retardant films or sheets produced therefrom. These films and
sheets have excellent appearance, flexibility, and flame retardancy, and can be used in a wide range of decorative and packaging
applications.



WO 2004/060990 A2

- 1 -

FLAME RETARDANT POLYESTER COMPOSITIONS FOR CALENDERING**CROSS REFERENCES TO RELATED APPLICATIONS**

[0001] This application claims the benefit of United States Provisional Application Serial No. 60/435,584 filed December 20, 2002.

TECHNICAL FIELD OF THE INVENTION

[0002] This invention pertains to polyester compositions for calendering and, more specifically, to flame retardant polyester compositions for calendering. The invention further pertains to calendering processes for flame retardant polyester compositions to produce a flame retardant film or sheet and to the flame retardant polyester film or sheet produced by such calendering processes.

BACKGROUND OF THE INVENTION

[0003] Calendering is an economic and highly efficient means to produce film and sheet from plastics such as plasticized and rigid poly(vinyl chloride), abbreviated herein as "PVC", and polypropylene compositions. The film and sheet usually have a thickness ranging from 2 mils (0.05 mm) to 80 mils (2.0 mm). Calendered PVC film or sheet are readily thermoformed into various shapes can be used in a wide range of applications including packaging, pool liners, graphic arts, transaction cards, security cards, veneers, wall coverings, book bindings, folders, floor tiles, and products which are printed, decorated, or laminated in a secondary operation. Additional discussion on polypropylene resin compositions used in calendering processes may be found in Japan Application No. Hei 7-197213 and European Patent Application No. 0 744 439 A1.

[0004] By contrast, conventional processing of polyesters into film or sheet involves extruding a polyester melt through a manifold of a flat die. Manual or automatic die lip adjustment is used to control thickness across a web of material. Water-cooled chill rolls are used to quench the molten web and impart a smooth surface finish. Although extrusion processes produce film and sheet of excellent quality, extrusion methods do not have the throughput and economic advantages of calendering processes.

[0005] PVC compositions are, by far, the largest segment of the calendered film and sheet business. Small amounts of other thermoplastic polymers such as, for example,

- 2 -

thermoplastic rubbers, certain polyurethanes, talc-filled polypropylene, acrylonitrile/butadiene/styrene terpolymers (ABS resins), and chlorinated polyethylene, are sometimes processed by calendering methods. By contrast, polyester polymers such as, for example, poly(ethylene terephthalate), abbreviated herein as "PET", or poly(1,4-butylene terephthalate), abbreviated herein as "PBT", are difficult to calender successfully. For example, PET polymers with inherent viscosity values of 0.6 dL/g have insufficient melt strength to perform properly on the calendering rolls. Also, when the polyester is fed to the rolls at typical processing temperatures of 160°C to 180°C, the PET polymer crystallizes causing a non-homogeneous mass which causes high forces on the calender bearings and is unsuitable for further processing. Another problem is the tendency of polyester polymers to hydrolyze during processing in the molten or semi-molten state on rolls exposed to atmospheric moisture. Typical PET polymers also have a tendency to stick to the calendering rolls at typical processing temperatures. Avoidance of these difficulties often requires a careful selection of polymer properties, additives, and processing conditions. The calendering of various polyester compositions has been described, for example, in U.S. Patent No.'s 5,998,005; 6,068,910; 6,551,688; U.S. Patent Application Serial No. 10/086,905; Japan Patent Application No.'s 8-283547; 2001-274010; 7-278418; 2000-243055; 10-363-908; 2000-310710; 2001-331315; 11-158358; and World Patent Application No. 02/28967.

[0006] Many current applications for calendered films have stringent flammability requirements. The calendered films prepared from polyesters typically do not show sufficient flame retardancy to be useful in many commercial applications. Further, the flame retardants often used with various polymer compositions often are not compatible with molten polyesters, are reactive with the polyester or its various additives, or do not impart the desired degree of flame retardancy at suitable concentrations.

[0007] To obtain film or sheet with desirable levels of flexibility, polymeric materials, such as PVC and cellulose esters must be plasticized before calendering. Most other thermoplastic resins, however, such as polyesters, polyamides and polyolefins, do not typically contain a plasticizer when processed in the molten state to form rigid molded or extruded objects. Plasticizers increase the flexibility and softness of calendered polyester films, improve the processing of the polyester, and help to prevent sticking of the polyester to the calender rolls. The addition of plasticizers, however, generally increases

- 3 -

the available fuel and results in increased flammability. The increased flammability of plasticized polyesters has created a need for flame-retardant, plasticized, polyester compositions suitable for the production of film and sheet by calendering as a more economical alternative to extrusion processes.

SUMMARY OF THE INVENTION

[0008] We have discovered that flame retardant polyester compositions suitable for calendering may be prepared from polyesters having crystallization half time of at least 5 minutes, a plasticizer, a flame retardant miscible with the plasticized polyester, and a release additive. Thus, the present invention provides a flame retardant polyester composition for calendering, comprising:

- (a) a polyester having a crystallization half time from a molten state of at least 5 minutes wherein the polyester is a random copolymer;
- (b) a plasticizer;
- (c) a phosphorus-containing flame retardant miscible with the polyester plasticized with the plasticizer; and
- (d) an additive effective to prevent sticking of the polyester to calendering rolls.

The polyester composition contains a polyester which is a random copolymer, an additive to prevent sticking of the polyester to the calender rolls, and a plasticizer, which provides the flexibility, softness, and processing characteristics that are particularly suitable for production of polyester films and sheets by calendering. The polyester composition also is flame retardant, which makes the film and sheet produced therefrom particularly desirable for commercial applications.

[0009] Another embodiment of the invention is a flame retardant polyester composition for calendering comprising:

- (a) 50 to 95 weight percent of a polyester having a melting temperature of less than 220°C and exhibiting more than 1 percent crystallinity after annealing for 2000 minutes at a temperature at which the polyester has a maximum crystallization rate, wherein the polyester is a random copolymer;
- (b) 5 to 50 wt% of a plasticizer miscible with the polyester, based on the total weight of the polyester composition; and

- 4 -

- (c) a phosphorus-containing flame retardant miscible with the polyester plasticized with the plasticizer.

For the latter composition the presence of additive to prevent sticking of the polyester to the calender rolls is optional. In addition, the present invention provides processes for flame retardant films or sheets by calendering the above compositions and for the flame retardant films or sheets produced therefrom. These films and sheets have an excellent appearance, flexibility, and flame retardancy and can be used in a great variety of decorative and packaging applications. The films and sheets are readily thermoformed into various shapes for specific packaging applications for both food and non-food products. They may be printed with a wide variety of inks and may be laminated either in-line or off-line with fabrics or other plastic films or sheets. Some specific end uses include graphic arts, transaction cards, security cards, veneers, wall coverings, book bindings, folders and the like.

DETAILED DESCRIPTION

[0010] Flame retardant polyester compositions may be calendered using conventional calendering processes to produce flame retardant films and sheets. Thus, in a general embodiment, the present invention provides a flame retardant polyester composition for calendering comprising a polyester having a crystallization half time from a molten state of at least 5 minutes in which the polyester is a random copolymer; a plasticizer; a phosphorus-containing flame retardant miscible with the polyester plasticized with the plasticizer; and an additive effective to prevent sticking of the polyester to calendering rolls. The invention further provides processes for flame retardant films or sheets and the film and sheets prepared therefrom. The calendered films and sheets typically have a thickness in the range of 2 mils (0.05 mm) to 80 mils (2 mm).

[0011] Unless indicated to the contrary, the numerical parameters set forth in the following specification and attached claims should at least be construed in light of the number of reported significant digits and by applying ordinary rounding techniques. Further, the ranges stated in this disclosure and the claims are intended to include the entire range specifically and not just the endpoint(s). For example, a range stated to be 0 to 10 is intended to disclose all whole numbers between 0 and 10 such as, for example 1, 2, 3, 4, etc., all fractional numbers between 0 and 10, for example 1.5, 2.3, 4.57, 6.1113, etc.,

- 5 -

and the endpoints 0 and 10. Also, a range associated with chemical substituent groups such as, for example, "C₁ to C₅ hydrocarbons", is intended to specifically include and disclose C₁ and C₅ hydrocarbons as well as C₂, C₃, and C₄ hydrocarbons.

[0012] Notwithstanding that the numerical ranges and parameters setting forth the broad scope of the invention are approximations, the numerical values set forth in the specific examples are reported as precisely as possible. Any numerical value, however, inherently contains certain errors necessarily resulting from the standard deviation found in their respective testing measurements.

[0013] The term "polyester", as used herein, is intended to include "copolyesters" and is understood to mean a synthetic polymer prepared by the polycondensation of one or more difunctional carboxylic acids with one or more difunctional hydroxyl compounds. Typically the difunctional carboxylic acid is a dicarboxylic acid and the difunctional hydroxyl compound is a dihydric alcohol such as, for example, glycols and diols. Alternatively, the difunctional carboxylic acid may be a hydroxy carboxylic acid such as, for example, p-hydroxybenzoic acid, and the difunctional hydroxyl compound may be an aromatic nucleus bearing 2 hydroxy substituents such as, for example, hydroquinone. The term "residue", as used herein, means any organic structure incorporated into a polymer or plasticizer through a polycondensation reaction involving the corresponding monomer. Thus, the dicarboxylic acid residue may be derived from a dicarboxylic acid monomer or its associated acid halides, esters, salts, anhydrides, or mixtures thereof. As used herein, therefore, the term dicarboxylic acid is intended to include dicarboxylic acids and any derivative of a dicarboxylic acid, including its associated acid halides, esters, half-esters, salts, half-salts, anhydrides, mixed anhydrides, or mixtures thereof, useful in a polycondensation process with a diol to make a high molecular weight polyester.

[0014] The flame retardant polyester compositions of present invention are prepared from polyesters comprising dicarboxylic acid residues, diol residues, and repeating units. A "repeating unit", as used herein, means an organic structure having a dicarboxylic acid and a diol residue bonded through a carbonyloxy group. The polyesters of the present invention contain substantially equal molar proportions of acid residues (100 mole%) and diol residues (100 mole%) which react in substantially equal proportions such that the total moles of repeating units is equal to 100 mole%. The mole percentages provided in the present disclosure, therefore, may be based on the total moles of acid residues, the total

- 6 -

moles of diol residues, or the total moles of repeating units. For example, a polyester containing 30 mole% isophthalic acid, based on the total acid residues, means the polyester contains 30 mole% isophthalic acid out of a total of 100 mole% acid residues. Thus, there are 30 moles of isophthalic acid among every 100 moles of acid residues. In another example, a polyester containing 30 mole% ethylene glycol, based on the total diol residues, means the polyester contains 30 mole% ethylene glycol out of a total of 100 mole% diol residues. Thus, there are 30 moles of ethylene glycol among every 100 moles of diol residues. In a third example, a polyester containing 30 mole% of a monomer, which may be a dicarboxylic acid, a diol, or hydroxycarboxylic acid, based on the total repeating units, means that the polyester contains 30 mole% monomer out of a total of 100 mole% repeating units. Thus, there are 30 moles of monomer residues among every 100 moles of repeating units.

[0015] The polyesters of this invention have a crystallization half time from a molten state of at least 5 minutes. The crystallization half time may be, for example, greater than 7 minutes, greater than 10 minutes, greater than 12 minutes, greater than 20 minutes, greater than 100 minutes, and greater than 300 minutes. Typically, polyesters exhibiting a crystallization half time of at least 5 minutes are copolyesters or random copolymers. The term "random copolymer", as used herein, means that the polyester comprises more than one diol and/or diacid residues in which the different diol or diacid residues are randomly distributed along the polymer chain. Thus, the polyesters of the instant invention are not "homopolymers" or "block copolymers". Preferably, the polyesters have a substantially amorphous morphology, meaning that the polyesters comprise substantially unordered regions of polymer. Amorphous or semicrystalline polymers typically exhibit either only a glass transition temperature (abbreviated herein as "T_g") alone or a glass transition temperature in addition to a melting point (abbreviated herein as "T_m"), as measured by well-known techniques such as, for example, differential scanning calorimetry ("DSC"). The desired crystallization kinetics from the melt also may be achieved by the addition of polymeric additives such as, for example, plasticizers, or by altering the molecular weight characteristics of the polymer. The polyesters of the invention also may be a miscible blend of a substantially amorphous polyester with a more crystalline polyester, combined in the proportions necessary to achieve a crystallization half time of at least 5 minutes. In a preferred embodiment, however, the polyesters of our invention are not blends.

- 7 -

[0016] The crystallization half time of the polyester, as used herein, may be measured using methods well-known to persons of skill in the art. For example, the crystallization half time may be measured using a Perkin-Elmer Model DSC-2 differential scanning calorimeter. The crystallization half time is measured from the molten state using the following procedure: a 15.0 mg sample of the polyester is sealed in an aluminum pan and heated to 290°C at a rate of about 320°C/min for 2 minutes. The sample is then cooled immediately to the predetermined isothermal crystallization temperature at a rate of about 320°C/minute in the presence of helium. The isothermal crystallization temperature is the temperature between the glass transition temperature and the melting temperature that gives the highest rate of crystallization. The isothermal crystallization temperature is described, for example, in Elias, H. *Macromolecules*, Plenum Press: NY, 1977, p 391. The crystallization half time is determined as the time span from reaching the isothermal crystallization temperature to the point of a crystallization peak on the DSC curve.

[0017] The polyester may comprise (i) at least 80 mole percent (mole%) of diacid residues comprising one or more of: terephthalic acid, naphthalenedicarboxylic acid, 1,4-cyclohexanedicarboxylic acid, or isophthalic acid; and (ii) diol residues comprising 10 to about 100 mole% 1,4-cyclohexanedimethanol and 0 to 90 mole% of one or more diols containing 2 to 20 carbon atoms, wherein the diacid residues are based on 100 mole% and the diol residues are based on 100 mole%. Any of the various isomers of naphthalenedicarboxylic acid or mixtures of isomers may be used, but the 1,4-, 1,5-, 2,6-, and 2,7- isomers are preferred. Also, cycloaliphatic dicarboxylic acids such as, for example, 1,4-cyclohexanedicarboxylic acid may be present at the pure *cis* or *trans* isomer or as a mixture of *cis* and *trans* isomers. In one embodiment, for example, the polyester may comprise 80 to 100 mole% of diacid residues from terephthalic acid and 0 to 20 mole% diacid residues from isophthalic acid.

[0018] The polyester may also further comprise from 0 to 20 mole percent of one or more modifying diacids containing from 4 to 40 carbon atoms. Examples of modifying dicarboxylic acids that may be used include aliphatic dicarboxylic acids, alicyclic dicarboxylic acids, aromatic dicarboxylic acids, or mixtures of two or more of these acids. Specific examples of modifying dicarboxylic acids include, but are not limited to, one or more of succinic acid, glutaric acid, adipic acid, suberic acid, sebacic acid, azelaic acid, dimer acid, or sulfoisophthalic acid. Additional examples of modifying diacid

- 8 -

acids are fumaric; maleic; itaconic; 1,3-cyclohexanedicarboxylic; diglycolic; 2,5-norbornanedicarboxylic; phthalic; diphenic; 4,4'-oxydibenzoic; and 4,4'-sulfonyldibenzoic.

[0019] The diol residues may comprise 10 to 100 mole% 1,4-cyclohexanedimethanol and 0 to 90 mole% of one or more diols containing 2 to 20 carbon atoms. As used herein, the term "diol" is synonymous with the term "glycol" and means any dihydric alcohol. Examples of diols include ethylene glycol; diethylene glycol; triethylene glycol; polyethylene glycols; 1,2-propanediol; 1,3-propanediol; 2,4-dimethyl-2-ethylhexane-1,3-diol; 2,2-dimethyl-1,3-propanediol; 2-ethyl-2-butyl-1,3-propanediol; 2-ethyl-2-isobutyl-1,3-propanediol; 1,3-butanediol; 1,4-butanediol; 1,5-pentanediol; neopentyl glycol; 1,6-hexanediol; 1,8-octanediol; 2,2,4-trimethyl-1,3-pentanediol; thiodiethanol; 1,2-cyclohexanedimethanol; 1,3-cyclohexanedimethanol; 2,2,4,4-tetramethyl-1,3-cyclobutanediol; p-xylylenediol; bisphenol A; bisphenol S; polyalkylene glycol; or combinations of one or more of these glycols. The cycloaliphatic diols, for example, 1,3- and 1,4-cyclohexanedimethanol, may be present as their pure *cis* or *trans* isomers or as a mixture of *cis* and *trans* isomers. In another example, the diol residues may comprise 10 to 100 mole percent 1,4-cyclohexanedimethanol and 0 to 90 mole% ethylene glycol. In yet another example, the diol residues may comprise 20 to 70 mole percent 1,4-cyclohexanedimethanol and 80 to 30 mole percent ethylene glycol.

[0020] The polyester composition of the instant invention has a glass transition temperature, abbreviated herein as "Tg", ranging from -45°C to 40°C, as measured using standard techniques well known to persons skilled in the art such as, for example, differential scanning calorimetry ("DSC"). The Tg measurements are typically conducted using a "dry polymer", that is, a polymer sample in which adventitious or absorbed water is driven off by heating the polymer to a temperature of 200°C and allowing the sample to return to room temperature. Usually, the polyester composition is dried in the DSC apparatus by conducting a first thermal scan in which the sample is heated to a temperature above the water vaporization temperature, holding the sample at that temperature until the vaporization of the water absorbed in the polymer is complete (as indicated by an a large, broad endotherm), cooling the sample to room temperature, and then conducting a second thermal scan to obtain the Tg measurement. Typically, the polyester composition has a Tg of 30°C or less. Further examples of glass transition

- 9 -

temperatures exhibited by the polyester composition are 25°C or less, 20°C or less, 10°C or less, and 0°C or less.

[0021] The inherent viscosity, abbreviated herein as "I.V.", of the polyesters of the invention generally ranges from 0.4 to 1.2 dL/g and, preferably, 0.5 to 1.0 dL/g. The term I.V. refers to inherent viscosity determinations made at 25°C using 0.25 gram of polymer per 50 mL of a solvent composed of 60 weight percent phenol and 40 weight percent tetrachloroethane.

[0022] The polyesters of the instant invention are readily prepared from the appropriate dicarboxylic acids, esters, anhydrides, or salts, and the appropriate diol or diol mixtures using typical polycondensation reaction conditions. They may be made by continuous, semi-continuous, and batch modes of operation and may utilize a variety of reactor types. Examples of suitable reactor types include, but are not limited to, stirred tank, continuous stirred tank, slurry, tubular, wiped-film, falling film, or extrusion reactors. The term "continuous" as used herein means a process wherein reactants are introduced and products withdrawn simultaneously in an uninterrupted manner. By "continuous" it is meant that the process is substantially or completely continuous in operation in contrast to a "batch" process. "Continuous" is not meant in any way to prohibit normal interruptions in the continuity of the process due to, for example, start-up, reactor maintenance, or scheduled shut down periods. The term "batch" process as used herein means a process wherein all the reactants are added to the reactor and then processed according to a predetermined course of reaction during which no material is fed or removed into the reactor. The term "semicontinuous" means a process where some of the reactants are charged at the beginning of the process and the remaining reactants are fed continuously as the reaction progresses. Alternatively, a semicontinuous process may also include a process similar to a batch process in which all the reactants are added at the beginning of the process except that one or more of the products are removed continuously as the reaction progresses. The process is operated advantageously as a continuous process for economic reasons and to produce superior coloration of the polymer as the polyester may deteriorate in appearance if allowed to reside in a reactor at an elevated temperature for too long a duration.

[0023] The polyesters of the present invention are prepared by procedures known to persons skilled in the art. The reaction of the diol component and the dicarboxylic acid

- 10 -

component may be carried out using conventional polyester polymerization conditions. For example, when preparing the polyester by means of an ester interchange reaction, i.e., from the ester form of the dicarboxylic acid components, the reaction process may comprise two steps. In the first step, the diol component and the dicarboxylic acid component, such as, for example, dimethyl terephthalate, are reacted at elevated temperatures, typically, 150°C to 250°C for 0.5 to 8 hours at pressures ranging from 0.0 kPa gauge to 414 kPa gauge (60 pounds per square inch, "psig"). Preferably, the temperature for the ester interchange reaction ranges from 180°C to 230°C for 1 to 4 hours while the preferred pressure ranges from 103 kPa gauge (15 psig) to 276 kPa gauge (40 psig). Thereafter, the reaction product is heated under higher temperatures and under reduced pressure to form the polyester with the elimination of diol, which is readily volatilized under these conditions and removed from the system. This second step, or polycondensation step, is continued under higher vacuum and a temperature which generally ranges from 230°C to 350°C, preferably 250°C to 310°C and, most preferably, 260°C to 290°C for 0.1 to 6 hours, or preferably, for 0.2 to 2 hours, until a polymer having the desired degree of polymerization, as determined by inherent viscosity, is obtained. The polycondensation step may be conducted under reduced pressure which ranges from 53 kPa (400 torr) to 0.013 kPa (0.1 torr). Stirring or appropriate conditions are used in both stages to ensure adequate heat transfer and surface renewal of the reaction mixture. The reaction rates of both stages are increased by appropriate catalysts such as, for example, alkoxy titanium compounds, alkali metal hydroxides and alcoholates, salts of organic carboxylic acids, alkyl tin compounds, metal oxides, and the like. A three-stage manufacturing procedure, similar to that described in U.S. Patent No. 5,290,631, may also be used, particularly when a mixed monomer feed of acids and esters is employed.

[0024] To ensure that the reaction of the diol component and dicarboxylic acid component by an ester interchange reaction is driven to completion, it is sometimes desirable to employ 1.05 to 2.5 moles of diol component to one mole dicarboxylic acid component. Persons of skill in the art will understand, however, that the ratio of diol component to dicarboxylic acid component is generally determined by the design of the reactor in which the reaction process occurs.

[0025] In the preparation of polyester by direct esterification, i.e., from the acid form of the dicarboxylic acid component, polyesters are produced by reacting the dicarboxylic

acid or a mixture of dicarboxylic acids with the diol component or a mixture of diol components. The reaction is conducted at a pressure of from 7 kPa gauge (1 psig) to 1379 kPa gauge (200 psig), preferably less than 689 kPa (100 psig) to produce a low molecular weight, linear or branched polyester product having an average degree of polymerization of from 1.4 to 10. The temperatures employed during the direct esterification reaction typically range from 180°C to 280°C, more preferably ranging from 220°C to 270°C. This low molecular weight polymer may then be polymerized by a polycondensation reaction.

[0026] The polyester composition also comprises a plasticizer. The presence of the plasticizer is useful to produce flexible materials having good mechanical properties. The plasticizer also helps to lower the processing temperature of the polyester and may help to prevent sticking of the polyester composition to the calender rolls. The plasticizers typically comprise one or more aromatic rings. The preferred plasticizers are soluble in the polyester as indicated by dissolving a 5-mil (.127 mm) thick film of the polyester to produce a clear solution at a temperature of 160°C or less. In another embodiment, the preferred plasticizers are soluble in the polyester as indicated by dissolving a 5-mil (.127 mm) thick film of the polyester to produce a clear solution at a temperature of 150°C or less. The solubility of the plasticizer in the polyester may be determined as follows:

1. Placing into a small vial a 1/2 inch section of a standard reference film, 5 mils (.127 mm) in thickness and about equal to the width of the vial.
2. Adding the plasticizer to the vial until the film is covered completely.
3. Placing the vial with the film and plasticizer on a shelf to observe after one hour and again at 4 hours. Note the appearance of the film and liquid.
4. After the ambient observation, placing the vial in a heating block and allow the temperature to remain constant at 75°C for one hour and observe the appearance of the film and liquid.
5. Repeating step 4 for each of the following temperatures (°C): 100, 140, 150, and 160,

[0027] Examples of plasticizers and their solubilities as determined by the above test are set forth in Table 1. A value of 4 or greater over the temperature indicates that this plasticizer is candidate for use in the present invention.

Table 1 – Solubilities of Plasticizers

TEMPERATURE (°C)	23	75	100	140	150	160
Adipic Acid Derivatives						
Dicapryl adipate	1	1	1	1	2	2
Di-(2-ethylhexyl adipate)	1	1	1	1	2	2
Di(n-heptyl, n-nonyl) adipate	1	1	1	1	2	2
Diisobutyl adipate	1	3	3	3	3	4
Diisodecyl adipate	1	1	1	1	1	1
Dinonyl adipate	1	1	1	1	1	2
Di-(tridecyl) adipate	1	1	1	1	1	1
Azelaic Acid Derivatives						
Di-(2-ethylhexyl azelate)	1	1	1	1	2	2
Diisodecyl azelate	1	1	1	1	1	1
Diisooctyl azelate	1	1	1	1	2	2
Dimethyl azelate	3	4	4	4	4	6
Di-n-hexyl azelate	1	1	2	2	3	3
Benzoic Acid Derivatives						
Diethylene glycol dibenzoate (DEGDB)	4	4	4	6	6	6
Dipropylene glycol dibenzoate	3	3	4	4	4	6
Propylene glycol dibenzoate	1	3	4	6	6	6
Polyethylene glycol 200 dibenzoate	4	4	4	4	6	6
Neopentyl glycol dibenzoate	0	3	3	3	4	6
Citric Acid Derivatives						
Acetyl tri-n-butyl citrate	1	1	1	2	3	3
Acetyl triethyl citrate	1	2	2	2	3	3
Tri-n-Butyl citrate	1	2	3	3	3	3,
Triethyl citrate	3	3	3	3	3	3
Dimer Acid Derivatives						
Bis-(2-hydroxyethyl dimerate)	1	1	1	1	2	3
Epoxy Derivatives						
Epoxidized linseed oil	1	2	2	2	3	3
Epoxidized soy bean oil	1	1	1	1	1	2

- 13 -

TEMPERATURE (°C)	23	75	100	140	150	160
2-Ethylhexyl epoxystallate	1	1	1	1	3	3
Fumaric Acid Derivatives						
Dibutyl fumarate	2	2	3	3	3	3
Glycerol Derivatives						
Glycerol Tribenzoate	0	0	6	6	6	6
Glycerol triacetate	2	3	3	3	3	4
Glycerol diacetate monolaurate	1	2	2	2	2	4
Isobutyrate Derivative						
2,2,4-Trimethyl-1,3-pentanediol, Diisobutyrate	1	1	1	1	3	3
Texanol diisobutyrate	1	2	2	2	2	4
Isophthalic Acid Derivatives						
Dimethyl isophthalate	0	5	5	6	6	6
Diphenyl isophthalate	0	0	0	0	0	0
Di-n-butylphthalate	2	3	3	3	3	3
Lauric Acid Derivatives						
Methyl laurate	1	2	3	3	3	3
Linoleic Acid Derivative						
Methyl linoleate, 75%	1	1	2	3	3	3
Maleic Acid Derivatives						
Di-(2-ethylhexyl) maleate	1	1	2	3	3	3
Di-n-butyl maleate	2	3	3	3	3	3
Mellitates						
Tricapryl trimellitate	1	1	1	1	1	1
Triisodecyl trimellitate	1	1	1	1	1	1
Tri-(n-octyl,n-decyl) trimellitate	1	1	1	1	1	1
Triisonyl trimellitate	1	1	1	1	1	1
Myristic Acid Derivatives						
Isopropyl myristate	1	1	1	2	3	3
Oleic Acid Derivatives						
Butyl oleate	1	1	1	2	3	3
Glycerol monooleate	0	1	1	1	3	3

- 14 -

TEMPERATURE (°C)	23	75	100	140	150	160
Glycerol trioleate	1	1	1	1	2	2
Methyl oleate	1	1	2	2	3	3
n-Propyl oleate	1	1	1	2	3	3
Tetrahydrofurfuryl oleate	1	1	1	2	3	3
Palmitic Acid Derivatives						
Isopropyl palmitate	1	1	1	1	2	3
Methyl palmitate	0	1	1	2	3	3
Paraffin Derivatives						
Chloroparaffin, 41% C1	1	1	2	2	2	3
Chloroparaffin, 50% C1	1	2	3	3	3	3
Chloroparaffin, 60% C1	1	5	6	6	6	6
Chloroparaffin, 70% C1	0	0	0	0	0	0
Phosphoric Acid Derivatives						
2-Ethylhexyl diphenyl phosphate	2	3	3	3	4	4
Isodecyl diphenyl phosphate	1	2	3	3	3	3
t-Butylphenyl diphenyl phosphate	1	3	3	4	6	6
Resorcinol bis(diphenyl phosphate) (RDP)						
100% RDP	1	1	1	3	3	3
Blend of 75% RDP, 25% DEGDB (by wt)	1	2	2	4	4	5
Blend of 50% RDP, 50% DEGDB (by wt)	1	2	5	6	6	6
Blend of 25% RDP, 75% DEGDB (by wt)	1	3	3	6	6	6
Tri-butoxyethyl phosphate	1	2	3	4	4	4
Tributyl phosphate	2	3	3	3	3	3
Tricresyl phosphate	1	3	3	4	6	6
Triphenyl phosphate	0	4	4	6	6	6
Phthalic Acid Derivatives						
Butyl benzyl phthalate	2	3	3	6	6	6
Texanol benzyl phthalate	2	2	2	2	2	4
Butyl octyl phthalate	1	1	2	2	3	3
Dicapryl phthalate	1	1	1	1	2	2
Dicyclohexyl phthalate	0	1	2	2	4	5

- 15 -

TEMPERATURE (°C)	23	75	100	140	150	160
Di-(2-ethylhexyl) phthalate	1	1	1	2	3	3
Diethyl phthalate	4	4	4	6	6	6
Dihexyl phthalate	1	2	3	3	3	3
Diisobutyl phthalate	1	3	3	3	3	5
Diisodecyl phthalate	1	1	1	1	2	2
Diisoheptyl phthalate	1	1	2	3	3	3
Diisononyl phthalate	1	1	1	1	2	3
Diisooctyl phthalate	1	1	2	2	3	3
Dimethyl phthalate	1	5	6	6	6	6
Ditridecyl phthalate	1	1	1	1	2	3
Diundecyl phthalate	1	1	1	2	2	2
Ricinoleic Acid Derivatives						
Butyl ricinoleate	1	1	2	3	3	3
Glycerol tri(acetyl) ricinlloate	1	1	1	2	1	1
Methyl acetyl ricinlloate	1	1	2	3	3	3
Methyl ricinlloate	1	2	3	3	3	4
n-Butyl acetyl ricinlloate	1	1	1	2	3	3
Propylene glycol ricinlloate	1	1	3	3	4	4
Sebacic Acid Derivatives						
Dibutyl sebacate	1	2	3	3	3	3
Di-(2-ethylhexyl) sebacate	1	1	1	2	2	3
Dimethyl sebacate	0	4	4	6	6	6
Stearic Acid Derivatives						
Ethylene glycol monostearate	0	1	2	3	3	3
Glycerol monostearate	0	0	1	2	2	2
Isopropyl isostearate	3	3	3	6	6	6
Methyl stearate	0	1	2	2	2	3
n-Butyl stearate	1	1	2	3	3	3
Propylene glycol monostearate	0	1	1	2	2	3
Succinic Acid Derivatives						
Diethyl succinate	3	3	4	5	6	6

- 16 -

TEMPERATURE (°C)	23	75	100	140	150	160
Sulfonic Acid Derivatives						
N-Ethyl o,p-toluenesulfonamide	2	5	6	6	6	6
o,p-toluenesulfonamide	0	0	0	6	6	6

Key:

0 = Plasticizer is a solid at this temperature

1 = Plasticizer is liquid, yet nothing happening to the film

2 = film has begun to haze

3 = film has swollen

4 = film has begun to change as disintegrating off and/or liquid becoming hazy

5 = no longer a film, liquid is hazy

6 = liquid is clear

[0028] A similar test to that above is described in "The Technology of Plasticizers", by J. Kern Sears and Joseph R. Darby, published by Society of Plastic Engineers/Wiley and Sons, New York, 1982, pp 136-137. In this test, a grain of the polymer is placed in a drop of plasticizer on a heated microscope stage. If the polymer disappears, then it is solubilized. The plasticizers that are most effective at solubilizing the polyester of the instant invention have a solubility of greater than 4 according to Table 1 and can also be classified according to their solubility parameter. The solubility parameter, or square root of the cohesive energy density, of a plasticizer can be calculated by the method described by Coleman et al., *Polymer* 31, 1187 (1990). The most preferred plasticizers will have a solubility parameter (δ) in the range of 9.5 to 13.0 $\text{cal}^{0.5}\text{cm}^{-1.5}$. It is generally understood that the solubility parameter of the plasticizer should be within 1.5 units of the solubility parameter of polyester. The data of Table 2 shows that plasticizers with a solubility parameter within this range solubilize the polyester while those plasticizers with a solubility parameter outside of this range are less effective.

Table 2

Plasticizer	δ ($\text{cal}^{0.5}\text{cm}^{-1.5}$)	Solubility @ 160°C from Table 1
Glycerol diacetate monolaurate	8.1	4
Texanol diisobutyrate	8.4	4
Di-2-ethylhexyladipate	8.5	2

- 17 -

Trioctyltrimellitate	8.8	1
Di-2-ethylhexylphthalate	8.9	2
Texanol benzyl phthalate	9.5	4
Neopentyl glycol dibenzoate	9.8	6
Dipropylene glycol dibenzoate	10.0	6
Butyl benzyl phthalate	10.1	6
Propylene glycol dibenzoate	10.3	6
Diethylene glycol dibenzoate	10.3	6
Glycerol tribenzoate	10.6	6

[0029] In general, higher molecular weight plasticizers are preferred to prevent smoking and loss of plasticizer during the calendering process. The preferred range of plasticizer content will depend on the properties of the base polyester and the plasticizer. In particular, as the Tg of the polyester as predicted by the well-known Fox equation (T.G. Fox, Bull. Am. Phys. Soc., 1, 123 (1956)) decreases, the amount of plasticizer needed to obtain a polyester composition that may be calendered satisfactorily also decreases. Typically, the plasticizer comprises from 5 to 50 weight percent (wt%) of the polyester composition based on the total weight of the polyester composition. Other examples of plasticizer levels are 10 to 40 wt%, 15 to 40 wt%, and 15 to 30 wt% of the polyester composition.

[0030] Examples of plasticizers which may be used according to the invention are esters comprising: (i) an acid residue comprising one or more of: phthalic acid, adipic acid, trimellitic acid, benzoic acid, azelaic acid, terephthalic acid, isophthalic acid, butyric acid, glutaric acid, citric acid or phosphoric acid; and (ii) an alcohol residue comprising one or more aliphatic, cycloaliphatic, or aromatic alcohols containing up to 20 carbon atoms. Further, non-limiting examples of alcohol residues of the plasticizer include methanol, ethanol, propanol, isopropanol, butanol, isobutanol, stearyl alcohol, lauryl alcohol, phenol, benzyl alcohol, hydroquinone, catechol, resorcinol, ethylene glycol, neopentyl glycol, 1,4-cyclohexanedimethanol, and diethylene glycol. The plasticizer also may comprise one or more benzoates, phthalates, phosphates, or isophthalates. In another example, the plasticizer comprises diethylene glycol dibenzoate, abbreviated herein as "DEGDB".

- 18 -

[0031] The polyester composition also comprises a phosphorus-containing flame retardant. The phosphorus-containing flame retardant is miscible with the plasticized polyester. The term "miscible", as used herein, is understood to mean that the flame retardant and the plasticized polyester will mix together to form a stable mixture which will not separate into multiple phases under processing conditions or conditions of use. Thus, the term "miscible" is intended to include both "soluble" mixtures, in which flame retardant and plasticized polyester form a true solution, and "compatible" mixtures, meaning that the mixture of flame retardant and plasticized polyester do not necessarily form a true solution but only a stable blend. Preferably, the phosphorus-containing compound is a non-halogenated, organic compound such as, for example, a phosphorus acid ester containing organic substituents. The flame retardant may comprise a wide range of phosphorus compounds well-known in the art such as, for example, phosphines, phosphites, phosphinites, phosphonites, phosphinates, phosphonates, phosphine oxides, and phosphates. Examples of phosphorus-containing flame retardants include tributyl phosphate, triethyl phosphate, tri-butoxyethyl phosphate, t-Butylphenyl diphenyl phosphate, 2-ethylhexyl diphenyl phosphate, ethyl dimethyl phosphate, isodecyl diphenyl phosphate, trilauryl phosphate, triphenyl phosphate, tricresyl phosphate, trixylenyl phosphate, t-butylphenyl diphenylphosphate, resorcinol bis(diphenyl phosphate), tribenzyl phosphate, phenyl ethyl phosphate, trimethyl thionophosphate, phenyl ethyl thionophosphate, dimethyl methylphosphonate, diethyl methylphosphonate, diethyl pentylphosphonate, dilauryl methylphosphonate, diphenyl methylphosphonate, dibenzyl methylphosphonate, diphenyl cresylphosphonate, dimethyl cresylphosphonate, dimethyl methylthionophosphonate, phenyl diphenylphosphinate, benzyl diphenylphosphinate, methyl diphenylphosphinate, trimethyl phosphine oxide, triphenyl phosphine oxide, tribenzyl phosphine oxide, 4-methyl diphenyl phosphine oxide, triethyl phosphite, tributyl phosphite, trilauryl phosphite, triphenyl phosphite, tribenzyl phosphite, phenyl diethyl phosphite, phenyl dimethyl phosphite, benzyl dimethyl phosphite, dimethyl methylphosphonite, diethyl pentylphosphonite, diphenyl methylphosphonite, dibenzyl methylphosphonite, dimethyl cresylphosphonite, methyl dimethylphosphinite, methyl diethylphosphinite, phenyl diphenylphosphinite, methyl diphenylphosphinite, benzyl diphenylphosphinite, triphenyl phosphine, tribenzyl phosphine, and methyl diphenyl phosphine.

- 19 -

[0032] The term "phosphorus acid" as used in describing the phosphorus-containing flame retardants of the invention include the mineral acids such as phosphoric acid, acids having direct carbon-to-phosphorus bonds such as the phosphonic and phosphinic acids, and partially esterified phosphorus acids which contain at least one remaining unesterified acid group such as the first and second degree esters of phosphoric acid and the like.

Typical phosphorus acids that can be employed in the present invention include, but are not limited to: dibenzyl phosphoric acid, dibutyl phosphoric acid, di(2-ethylhexyl) phosphoric acid, diphenyl phosphoric acid, methyl phenyl phosphoric acid, phenyl benzyl phosphoric acid, hexylphosphonic acid, phenylphosphonic acid, tolylphosphonic acid, benzylphosphonic acid, 2-phenylethylphosphonic acid, methylhexylphosphonic acid, diphenylphosphonic acid, phenylnaphthylphosphonic acid, dibenzylphosphonic acid, methylphenylphosphonic acid, phenylphosphonous acid, tolylphosphonous acid, benzylphosphonous acid, butyl phosphoric acid, 2-ethyl hexyl phosphoric acid, phenyl phosphoric acid, cresyl phosphoric acid, benzyl phosphoric acid, phenyl phosphorous acid, cresyl phosphorous acid, benzyl phosphorous acid, diphenyl phosphorous acid, phenyl benzyl phosphorous acid, dibenzyl phosphorous acid, methyl phenyl phosphorous acid, phenyl phenylphosphonic acid, tolyl methylphosphonic acid, ethyl benzylphosphonic acid, methyl ethylphosphonous acid, methyl phenylphosphonous acid, and phenyl phenylphosphonous acid. The flame retardant typically comprises one or more monoesters, diesters, or triesters of phosphoric acid. In another example, the flame retardant comprises resorcinol bis(diphenyl phosphate), abbreviated herein as "RDP".

[0033] The flame retardant may be added to the polyester composition at a concentration of 5 wt% to 40 wt% based on the total weight of the polyester composition. Other examples of the flame retardant levels are 7 wt% to 35 wt%, 10 wt% to 30 wt%, and 10 wt% to 25 wt%. The flame retardant polyester compositions of the present invention typically give a V2 or greater rating in a UL94 burn test. In addition, our flame retardant polyester compositions typically give a burn rate of 0 in the Federal Motor Vehicle Safety Standard 302 (typically referred to as FMVSS 302).

[0034] The phosphorus-containing flame retardant may also function as a plasticizer for the polyester. In this embodiment, the flame retardant may be substituted for a portion or all of the plasticizer component of the polyester composition, depending on the flame retardant's effectiveness as a plasticizer. Typically, when a plasticizing flame retardant is

- 20 -

used, the amount of flame retardant need to achieve the desired burn rate or flame resistance of the calendered film or sheet is determined first, then the amount of plasticizer needed to produce the desired Tg of the film or sheet is adjusted.

[0035] A preferred embodiment of the instant invention is a flame retardant polyester composition for calendering, comprising:

- (a) a polyester having a crystallization half time from a molten state of at least 10 minutes wherein the polyester is a random copolymer comprising (i) at least 80 mole percent of diacid residues comprising one or more of: terephthalic acid, naphthalenedicarboxylic acid, 1,4-cyclohexanedicarboxylic acid, or isophthalic acid; and (ii) diol residues comprising 20 to 40 mole percent 1,4-cyclohexanedimethanol and 60 to 80 mole percent of one or more diols containing 2 to 20 carbon atoms, wherein the diacid residues are based on 100 mole percent and the diol residues are based on 100 mole percent;
 - (b) 10 wt% to 40 wt% of plasticizer comprising one or more benzoates, phthalates, phosphates, or isophthalates;
 - (c) 5 wt% to 40 wt% of a phosphorus-containing flame retardant miscible with the polyester plasticized with the plasticizer; and
 - (d) an additive effective to prevent sticking of the polyester to calendering rolls,
- wherein the wt% is based upon the total weight of the polyester composition. Any of the various isomers of naphthalenedicarboxylic acid or mixtures of isomers may be used, but the 1,4-, 1,5-, 2,6-, and 2,7- isomers are preferred. Also, 1,4-cyclohexanedicarboxylic acid may be present at the pure *cis* or *trans* isomer or as a mixture of *cis* and *trans* isomers. The diols, modifying diacids, and flame retardants are as described previously. The preferred plasticizer comprises one or more benzoates, phthalates, phosphates, or isophthalates, such as listed, for example, in Table 1. Examples of preferred plasticizers include, but are not limited to, neopentyl glycol dibenzoate, diethylene glycol dibenzoate, butyl benzyl phthalate; and texanol benzyl phthalate. Most preferably, the plasticizer comprises diethylene glycol dibenzoate and the flame retardant comprises resorcinol bis(diphenyl phosphate).

[0036] In addition to the polyester, the polyester compositions described above comprise an additive that is effective to prevent sticking of the polyester to the calendering rolls. As used herein, the term "effective" means that the polyester passes freely between

- 21 -

the calendering rolls without wrapping itself around the rolls or producing an excessive layer of polyester on the surface of the rolls. The amount of additive used in the polyester resin composition is typically 0.1 to 10 wt% based on the total weight percent of the polyester composition. The optimum amount of additive used is determined by factors well known in the art and is dependent upon variations in equipment, material, process conditions, and film thickness. Examples of additives of the present invention include fatty acid amides such as erucylamide and stearamide; metal salts of organic acids such as calcium stearate and zinc stearate; fatty acids, fatty acid salts, and fatty acid esters such as stearic acid, oleic acid, and palmitic acid; hydrocarbon waxes such as paraffin wax, phosphoric acid esters, polyethylene waxes, and polypropylene waxes; chemically modified polyolefin waxes; ester waxes such as carnauba wax; metal salts in waxes; glycerin esters such as glycerol mono- and di-stearates; talc; microcrystalline silica; and acrylic copolymers (for example, PARALOID[®] K175 available from Rohm & Haas). The preferred additive comprises erucylamide, stearamide, calcium stearate, zinc stearate, stearic acid, oleic acid, palmitic acid, paraffin wax, polyethylene waxes, polypropylene waxes, carnauba wax, glycerol monostearate, and glycerol distearate. More preferably, the amount of additive in the polyester composition is 0.1 to 2 wt%.

[0037] A preferred additive comprises a fatty acid or a salt of a fatty acid containing more than 18 carbon atoms and (ii) an ester wax comprising a fatty acid residue containing more than 18 carbon atoms and an alcohol residue containing from 2 to 28 carbon atoms. The ratio of the fatty acid or salt of a fatty acid to the ester wax may be 1:1 or greater. In this embodiment, the combination of the fatty acid or fatty acid salt and an ester wax at the above ratio gives the additional benefit of providing a film or sheet with a haze value of less than 5%. The additives with fatty acid components containing 18 or less carbon atoms have a lower molecular weight and, thus, become miscible with the polyester. Such miscible additives have less interfacial migration surface qualities resulting in poor release or an increase in haze. In another example, the ratio of the fatty acid or salt of the fatty acid to the ester wax is 2:1 or greater.

[0038] The fatty acid may comprise montanic acid in which the salt of the fatty acid may comprise one or more of: the sodium salt of montanic acid, the calcium salt of montanic acid, or the lithium salt of montanic acid. The fatty acid residue of the ester wax may comprise montanic acid. The alcohol residue of the ester wax preferably contains 2 to

- 22 -

28 carbon atoms. Examples of alcohols include montanyl alcohol, ethylene glycol, butylene glycol, glycerol, and pentaerythritol. The additive may also comprise an ester wax which has been partially saponified with a base such as, for example, calcium hydroxide.

[0039] Oxidative stabilizers also may be used with polyesters of the present invention to prevent oxidative degradation during processing of the molten or semi-molten material on the rolls. Such stabilizers include esters such as distearyl thiodipropionate or dilauryl thiodipropionate; phenolic stabilizers such as IRGANOX[®] 1010 available from Ciba-Geigy AG, ETHANOX[®] 330 available from Ethyl Corporation, and butylated hydroxytoluene; and phosphorus containing stabilizers such as IRGAFOS[®] available from Ciba-Geigy AG and WESTON[®] stabilizers available from GE Specialty Chemicals. These stabilizers may be used alone or in combinations.

[0040] In the event that the melt viscosity and the melt strength of the polyester are insufficient for suitable processing on the calendering equipment, a melt strength enhancer may be used. Typically, melt strength may be increased by the addition of small amounts (0.1 to 2.0 mole %) of a branching agent to the polyesters either during their initial preparation or during subsequent blending or feeding procedures prior to reaching the calendering equipment. Suitable branching agents include multifunctional acids or glycols such as trimellitic acid, trimellitic anhydride, pyromellitic dianhydride, trimethylolpropane, glycerol, pentaerythritol, citric acid, tartaric acid, 3-hydroxyglutaric acid and the like. These branching agents may be added directly to the polyester or blended with the polyester in the form of a concentrate as described in U.S. 5,654,347 and U.S. 5,696,176. It is also possible to use agents such as sulfoisophthalic acid to increase the melt strength of the polyester to a desirable level. In addition, the polyester compositions may contain dyes, pigments, fillers, matting agents, antiblocking agents, antistatic agents, blowing agents, chopped fibers, glass, impact modifiers, carbon black, talc, TiO₂ and the like as desired. Colorants, sometimes referred to as toners, may be added to impart a desired neutral hue and/or brightness to the polyester and the calendered product.

[0041] The components of the polyester composition may be blended in batch, semicontinuous, or continuous processes. Small scale batches may be readily prepared in any high-intensity mixing devices well-known to those skilled in the art, such as Banbury

mixers, prior calendering. The components also may be blended in solution in an appropriate solvent. The melt blending method includes blending the polyester, plasticizer, flame retardant, additive, and any additional components at a temperature sufficient to melt the polyester. The blend may be cooled and pelletized for further use or the melt blend can be calendered directly from this molten blend into film or sheet. The term "melt" as used herein includes, but is not limited to, merely softening the polyester. For melt mixing methods generally known in the polymer art, see "Mixing and Compounding of Polymers" (I. Manas-Zloczower & Z. Tadmor editors, Carl Hanser Verlag Publisher, 1994, New York, N. Y.). When colored sheet or film is desired, pigments or colorants may be included in the polyester mixture during the reaction of the diol and the dicarboxylic acid or they may be melt blended with the preformed polyester. A preferred method of including colorants is to use a colorant having thermally stable organic colored compounds having reactive groups such that the colorant is copolymerized and incorporated into the polyester to improve its hue. For example, colorants such as dyes possessing reactive hydroxyl and/or carboxyl groups, including, but not limited to, blue and red substituted anthraquinones, may be copolymerized into the polymer chain. When dyes are employed as colorants, they may be added to the polyester reaction process after an ester interchange or direct esterification reaction.

[0042] The instant invention also provides a process for a flame retardant film or a sheet, comprising: calendering a polyester composition comprising (a) a polyester having a crystallization half time from a molten state of at least 5 minutes, wherein the polyester is a random copolymer; (b) a plasticizer; (c) a phosphorus-containing flame retardant miscible with the polyester plasticized with the plasticizer; and (d) an additive effective to prevent sticking of the polyester to calendering rolls. The polyesters, plasticizers, flame retardants, and additives are as described hereinabove for the other embodiments of the invention. The polyester, which is a random copolymer, has a crystallization half time of at least 5 minutes. The crystallization half time may be, for example, greater than 7 minutes, greater than 10 minutes, greater than 12 minutes, greater than 20 minutes, greater than 100 minutes, and greater than 300 minutes. The film or sheet of the instant invention has a T_g ranging from -45°C to 40°C. Typically, the film or sheet has a T_g of 30°C or less. Further examples of glass transition temperatures exhibited by the film or sheet are 25°C or less, 20°C or less, 10°C or less, and 0°C or less.

- 24 -

[0043] The preferred plasticizer comprises one or more aromatic rings and, more preferably, comprises one or more benzoates, phthalates, phosphates, or isophthalates, such as listed, for example, in Table 1. Examples of plasticizers include, but are not limited to, neopentyl glycol dibenzoate, diethylene glycol dibenzoate, butyl benzyl phthalate; and texanol benzyl phthalate. Typically, the plasticizer comprises from 5 to 50 weight percent (wt%) of the polyester composition based on the total weight of the polyester composition. Other examples of plasticizer levels are 10 to 40 wt%, 15 to 40 wt%, and 15 to 30 wt% of the polyester composition.

[0044] The flame retardant may be added to the polyester composition at a concentration of 5 wt% to 40 wt% based on the total weight of the polyester composition. Other examples of the flame retardant levels are 7 wt% to 35 wt%, 10 wt% to 30 wt%, and 10 wt% to 25 wt%. Preferably, the flame retardant comprises one or more monoesters, diesters, or triesters of phosphoric acid. The phosphorus-containing flame retardant may also function as a plasticizer for the polyester. In another example, the plasticizer comprises diethylene glycol dibenzoate and the flame retardant comprises resorcinol bis(diphenyl phosphate). The flame retardant film or sheet will typically give a V2 or greater rating in a UL94 burn test. In addition, our flame retardant film or sheet typically gives a burn rate of 0 in the Federal Motor Vehicle Safety Standard 302 (typically referred to as FMVSS 302).

[0045] Preferred additives comprise 0.1 wt% to 10 wt%, based on the total weight of the polyester composition, of one or more fatty acid amides, metal salts of organic acids, fatty acids, fatty acid esters, hydrocarbon waxes, phosphoric acid esters, chemically modified polyolefin waxes, glycerin esters, talc, or acrylic copolymers. In addition, the additive may comprise (i) a fatty acid or a salt of a fatty acid containing more than 18 carbon atoms and (ii) an ester wax comprising a fatty acid residue containing more than 18 carbon atoms and an alcohol residue containing from 2 to 28 carbon atoms. Preferably, the ratio of the fatty acid or salt of the fatty acid to the ester wax is 1:1 or greater. The preferred fatty acid comprises montanic acid and the preferred salt of the fatty acid comprises one or more of: the sodium salt of montanic acid, the calcium salt of montanic acid, or the lithium salt of montanic acid. In addition, the preferred fatty acid residue of the ester wax comprises montanic acid.

[0046] Conventional calendering processes and equipment are utilized to calender the polyester composition. In the process of the invention, polyester composition may comprise a molten, pellet or powder form and is passed through a compressive nip between at least two calendering rolls at temperatures of 100°C to 200°C. Typically, the polyester is blended with the plasticizer, flame retardants, additive, and other components. The mixed ingredients are plasticized in a kneader or extruder. Through heat, shearing, and pressure, the dry powders are fused to form a homogeneous, molten material. The extruder feeds the molten material in a continuous process to the top of the calendering section of the calendering line in between first and second heated calender rolls. Typically, four rolls are used to form three nips or gaps. For example, the rolls may be configured in an "L" shape, an inverted "L" shape, or a "Z" configuration. The rolls vary in size to accommodate different film widths. The rolls have separate temperature and speed controls. The material proceeds through the nip between the first two rolls, referred to as the feed nip. The rolls rotate in opposite directions to help spread the material across the width of the rolls. The material winds between the first and second, second and third, third and fourth rolls, etc. The gap between rolls decreases in thickness between each of the rolls so that the material is thinned between the sets of rolls as it proceeds. Typical processing temperatures for the rolls will generally range from 80°C to 220°C, preferably 100°C to 200°C, and more preferably 130°C to 180°C. For some hydrolytically unstable polyesters, predrying the polyester resin composition or venting excess moisture during processing is desirable to prevent polymer degradation by hydrolysis. After passing through the calender section, the material moves through another series of rolls where it is stretched and gradually cooled forming a film or sheet. The material also may be embossed or annealed before cooling. The cooled material is then wound onto master rolls. General descriptions of calendering processes are disclosed in Jim Butschli, *Packaging World*, p. 26-28, June 1997 and W.V. Titow, *PVC Technology*, 4th Edition, pp. 803-848 (1984), Elsevier Publishing Co.

[0047] The resulting film or sheet made from the polyester composition of the present invention has a uniform thickness that is produced by passing the polyester resin composition through the compressive nips between the heated rolls. In effect, the polyester resin composition is squeezed between the nips which separate the rolls. Each successive

nip between the calendering rolls reduces in opening size to obtain the final film or sheet gauge.

[0048] The invention further includes a flame retardant film or sheet comprising a polyester composition, the polyester composition comprising (a) a polyester having a crystallization half time from a molten state of at least 5 minutes, wherein the polyester is a random copolymer; (b) a plasticizer; (c) a phosphorus-containing flame retardant miscible with the polyester plasticized with the plasticizer; and (d) an additive effective to prevent sticking of the polyester to calendering rolls wherein the film or sheet is prepared by calendering the polyester composition. The polyesters, plasticizers, flame retardants, and additives are as described hereinabove for the other embodiments of the invention. The polyester, which is a random copolymer, has a crystallization half time of at least 5 minutes. The crystallization half time may be, for example, greater than 7 minutes, greater than 10 minutes, greater than 12 minutes, greater than 20 minutes, greater than 100 minutes, and greater than 300 minutes. The film or sheet preferably has a T_g of 30°C or less. Further examples of glass transition temperatures exhibited by the polyester composition are 25°C or less, 20°C or less, 10°C or less, and 0°C or less. The preferred plasticizer comprises one or more aromatic rings and, more preferably, comprises one or more benzoates, phthalates, phosphates, or isophthalates, such as listed, for example, in Table 1. Examples of plasticizers include, but are not limited to, neopentyl glycol dibenzoate, diethylene glycol dibenzoate, butyl benzyl phthalate; and texanol benzyl phthalate. Typically, the plasticizer comprises from 5 to 50 weight percent (wt%) of the polyester composition based on the total weight of the polyester composition. Other examples of plasticizer levels are 10 to 40 wt%, 15 to 40 wt%, and 15 to 30 wt% of the polyester composition.

[0049] The flame retardant may be added to the polyester composition at a concentration of 5 wt% to 40 wt% based on the total weight of the polyester composition. Other examples of the flame retardant levels are 7 wt% to 35 wt%, 10 wt% to 30 wt%, and 10 wt% to 25 wt%. Preferably, the flame retardant comprises one or more monoesters, diesters, or triesters of phosphoric acid. The phosphorus-containing flame retardant may also function as a plasticizer for the polyester. Most preferably, the plasticizer comprises diethylene glycol dibenzoate and the flame retardant comprises resorcinol bis(diphenyl phosphate). The flame retardant film or sheet will typically give a V2 or greater rating in a

- 27 -

UL94 burn test. In addition, our flame retardant film or sheet typically gives a burn rate of 0 in the Federal Motor Vehicle Safety Standard 302 (typically referred to as FMVSS 302).

[0050] Preferred additives comprise 0.1 wt% to 10 wt%, based on the total weight of the polyester composition, of one or more fatty acid amides, metal salts of organic acids, fatty acids, fatty acid salts, fatty acid esters, hydrocarbon waxes, phosphoric acid esters, chemically modified polyolefin waxes, ester waxes, glycerin esters, talc, or acrylic copolymers. In addition, the additive may comprise (i) a fatty acid or a salt of a fatty acid containing more than 18 carbon atoms and (ii) an ester wax comprising a fatty acid residue containing more than 18 carbon atoms and an alcohol residue containing from 2 to 28 carbon atoms. Preferably, the ratio of the fatty acid or salt of the fatty acid to the ester wax is 1:1 or greater. The fatty acid preferably comprises montanic acid and the salt of the fatty acid preferably comprises one or more of: the sodium salt of montanic acid, the calcium salt of montanic acid, or the lithium salt of montanic acid. The fatty acid residue of the ester wax preferably comprises montanic acid.

[0051] In addition to the embodiments described above, the instant invention also provides a flame retardant polyester composition for calendering in which the inclusion of an additive to prevent sticking of the polyester composition to the calender rolls is optional. Thus, the invention provides a flame retardant polyester composition for calendering, comprising: (a) 50 to 95 weight percent of a polyester having a melting temperature of less than 220°C and exhibiting more than 1 percent crystallinity after annealing for 2000 minutes at a temperature at which the polyester has a maximum crystallization rate, wherein the polyester is a random copolymer; (b) 5 to 50 wt% of a plasticizer miscible with the polyester, based on the total weight of the polyester composition; and (c) a phosphorus-containing flame retardant miscible with the polyester plasticized with the plasticizer. The polyesters, plasticizers, and flame retardants are as described hereinabove. The polyester may be a random copolymer having a melting temperature of less than 220°C and exhibiting more than 1 percent crystallinity after annealing for 2000 minutes at a temperature at which the polyester has a maximum crystallization rate. The percent crystallinity of the polyester may be determined by comparing the heat of fusion of the polyester, as determined by differential scanning calorimetry, against a 100% crystalline poly(ethylene) terephthalate reference value of 29 cal/g. the maximum crystallization rate for the polyester may be calculated or determined

- 28 -

experimentally by DSC using methods well known to persons skilled in the art. Typically, the crystallization half time of the polyester is greater than 5 minutes; other examples of crystallization half times which may be exhibited by the polyester are greater than 7 minutes, greater than 10 minutes, greater than 12 minutes, greater than 20 minutes, greater than 100 minutes, and greater than 300 minutes. The polyester composition preferably has a Tg of 30°C or less. Further examples of glass transition temperatures exhibited by the polyester composition are 25°C or less, 20°C or less, 10°C or less, and 0°C or less.

[0052] The polyester composition may comprise 5 to 50 wt% of a plasticizer miscible with the polyester, 10 wt% to 40 wt%, or 15 to 40 wt%. The preferred plasticizer comprises one or more aromatic rings and, more preferably, comprises one or more benzoates, phthalates, phosphates, or isophthalates, such as listed, for example, in Table 1. Examples of plasticizers include, but are not limited to, neopentyl glycol dibenzoate, diethylene glycol dibenzoate, butyl benzyl phthalate; and texanol benzyl phthalate.

[0053] The flame retardant may be added to the polyester composition at a concentration of 5 wt% to 40 wt% based on the total weight of the polyester composition. Other examples of the flame retardant levels are 7 wt% to 35 wt%, 10 wt% to 30 wt%, and 10 wt% to 25 wt%. Preferably, the flame retardant comprises one or more monoesters, diesters, or triesters of phosphoric acid. The phosphorus-containing flame retardant may also function as a plasticizer for the polyester. Most preferably, the plasticizer comprises diethylene glycol dibenzoate and the flame retardant comprises resorcinol bis(diphenyl phosphate). The polyester composition may optionally include an additive effective for preventing sticking of the polyester to the calender rolls. This additive has been described previously as part of the other embodiments of the instant invention. The flame retardant polyester composition will typically give a V2 or greater rating in a UL94 burn test. In addition, our flame retardant polyester compositions typically give a burn rate of 0 in the Federal Motor Vehicle Safety Standard 302 (typically referred to as FMVSS 302).

[0054] The polyester composition may be formed into a film or sheet by calendering the polymer composition and inducing crystallization either before or after the calendering process. Thus, another embodiment of the instant invention is a process for a flame retardant film or a sheet, comprising: (i) calendering a polyester composition comprising (a) 50 to 95 weight percent of a polyester having a melting temperature of less than 220°C and exhibiting more than 1 percent crystallinity after annealing for 2000 minutes at a

- 29 -

temperature at which the polyester has a maximum crystallization rate, wherein the polyester is a random copolymer; (b) 5 to 50 wt% of a plasticizer miscible with the polyester, based on the total weight of the polyester composition; and (c) a phosphorus-containing flame retardant miscible with the polyester plasticized with the plasticizer and (ii) inducing crystallization during step (i) or after step (i). Further, the invention includes the film or sheet prepared by the above process. Thus, another aspect of the invention is a flame retardant film or sheet, comprising: (a) 50 to 95 weight percent of a polyester having a melting temperature of less than 220°C and exhibiting more than 1 percent crystallinity after annealing for 2000 minutes at a temperature at which the polyester has a maximum crystallization rate, wherein the polyester is a random copolymer; (b) 5 to 50 weight percent of a plasticizer miscible with the polyester; and (c) a phosphorus-containing flame retardant miscible with the polyester plasticized with the plasticizer. The polyesters, plasticizers, and flame retardants are as described hereinabove. The calendering process conditions are as described previously; the polyester composition typically comprises a molten, pellet or powder form and is passed through a compressive nip between at least two calendering rolls at temperatures of 100°C to 200°C. The polyester is random copolymer and has a melting temperature of less than 220°C and exhibits more than 1 percent crystallinity after annealing for 2000 minutes at a temperature at which the polyester has a maximum crystallization rate. Typically, the crystallization half time of the polyester is greater than 5 minutes; other examples of crystallization half times which may be exhibited by the polyester are greater than 7 minutes, greater than 10 minutes, greater than 12 minutes, greater than 20 minutes, greater than 100 minutes, and greater than 300 minutes. The film or sheet of the instant invention has a T_g ranging from -45°C to 40°C, preferably 30°C or less, and a melting temperature greater than 120°C, preferably greater than 140°C. Further examples of glass transition temperatures exhibited by the polyester are less than 25°C, less than 20°C, less than 10°C, and less than 0°C.

[0055] The polyester composition comprises 5 to 50 wt% of a plasticizer miscible with the polyester, preferably 10 wt% to 40 wt%, or more preferably from 15 to 40 wt%. The preferred plasticizer comprises one or more aromatic rings and may comprise, for example, one or more benzoates, phthalates, phosphates, or isophthalates, such as listed in Table 1. Examples of plasticizers include, but are not limited to, neopentyl glycol

- 30 -

dibenzoate, diethylene glycol dibenzoate, butyl benzyl phthalate; and texanol benzyl phthalate.

[0056] The flame retardant may be added to the polyester composition at a concentration of 5 wt% to 40 wt% based on the total weight of the polyester composition. Other examples of the flame retardant levels are 7 wt% to 35 wt%, 10 wt% to 30 wt%, and 10 wt% to 25 wt%. The flame retardant may comprise one or more monoesters, diesters, or triesters of phosphoric acid. The phosphorus-containing flame retardant may also function as a plasticizer for the polyester. Most preferably, the plasticizer comprises diethylene glycol dibenzoate and the flame retardant comprises resorcinol bis(diphenyl phosphate). The polyester composition may optionally include an additive effective for preventing sticking of the polyester to the calender rolls. This additive has been described hereinabove as part of the other embodiments of the instant invention. The flame retardant film or sheet will typically give a V2 or greater rating in a UL94 burn test. In addition, our flame retardant film or sheet typically gives a burn rate of 0 in the Federal Motor Vehicle Safety Standard 302 (typically referred to as FMVSS 302).

[0057] In step (ii) of the present invention, the polyester composition is calendered to form a film or sheet and crystallization is induced. Inducing crystallization may be done either during or after forming the calendering operation. In one embodiment, inducing crystallization occurs after calendering by stretching. In another embodiment, inducing crystallization occurs after calendering by annealing at a temperature greater than the glass transition temperature of the film and less than melting temperature of the base copolyester. In still another embodiment, forming of the film or sheet and inducing crystallization occur together during step (i) by calendering alone.

[0058] The invention is illustrated further by the following examples.

EXAMPLES

[0059] A general procedure for the preparation of a flame-retardant polyester composition and a process for calendering follows. Flame retardant polyester compositions were prepared by melt blending a pelletized polyester with a composition having 80 to 100 wt% terephthalic acid, 30 to 80 wt% ethylene glycol, and 20 to 70 wt% 1,4-cyclohexanedimethanol (Tsunami[®] Copolyester GS-2, available from Eastman Chemical Company) melt blended with a release additive concentrate (Tsunami[®] ADD2,

- 31 -

available from Eastman Chemical Company, which contains 15 wt% of a mixture of Montan waxes, available from Clariant Corporation, and pre-compounded into Tsunami[®] Copolyester GS-2). A plasticizer (diethyleneglycol dibenzoate or DEGDB, obtained from Velsicol Chemical Corporation), a phosphate ester flame retardant, and various fillers and colorants (such as, for example, a TiO₂ colorant concentrate, produced by Eastman Chemical Company) also were melt blended with the polyester to form a flexible polyester material which could be processed by calendering methods. It was not necessary to dry the polyester pellets for the experiment as earlier experiments had shown that hydrolysis of the polyester is not significant at the low melt temperatures used in this study. The mixing experiments were performed on a Haake-Buchler Rheocord[®] System 40 using a bowl charge of 375 grams and a bowl temperature of 130°C. The blade speed in the batch mixer was 100 rpm. For each example, a LabView[®] computer system was employed to record torque and temperature as a function of time. After the torque of the mixing bowl reached its peak value, the mixing was allowed to continue until the melt temperature reached 150°C before the experiment was terminated and the contents of the mixing bowl were removed. Films were calendered on a Dr. Collin instrumented two roll mill. Because of the varied plasticization effects to the polymer system by the flame retardants, the processing roll set point temperature varied from 140 to 150° C in order to have adequate melt strength and roll release for removal from the rolls.

[0060] The selection of DEGDB as a plasticizer was made based on its effectiveness to reduce T_g, copolyester compatibility, and clarity of the calendered material. Other plasticizers such as butyl benzyl phthalate, dipropyleneglycol dibenzoate, neopentyl glycol dibenzoate, propylene glycol dibenzoate and 2-ethyl hexyl-4-hydroxy benzoate may be used in this application.

[0061] Although examples 1-12 are for colored opaque formulations, the results are applicable to clear un-filled systems as well. It is possible also to add other flame-retardants to the system such as melamine polyphosphate, melamine cyanurate, magnesium hydroxide, aluminum trihydrate, and various other commercially available materials such as Flamblac[®] metaborate (available from Buckman Laboratories). Results are presented in Tables 3-7.

[0062] *Examples 1-12.* The composition and burn test results using resorcinol bis(diphenyl phosphate), "RDP", as the flame retardant are given in Table 3 and Table 4.

- 32 -

Burn tests were conducted according to the UL94 burn test or the Federal Motor Vehicle Safety Standard 302 (typically referred to as FMVSS 302). Examples 1, 2, and 3 are white opaque formulations with calcium carbonate filler, and examples 4, 5, and 6 are white opaque formulations with kaolin filler. Examples 7, 8, and 9 are black opaque formulations with calcium carbonate filler, and examples 10, 11, and 12 are black opaque formulations with kaolin filler.

[0063] As can be seen from the data, the presence of RDP in the copolyester compositions reduced burn rates. The addition of RDP to the copolyester composition improved the burn ratings in the UL94 vertical burn test and reduced the burn rate in the FMVSS 302 horizontal burn test. Examples 1, 4, 7, and 10, contained no flame retardant. In these examples, a UL94 vertical burn rating of Fail was obtained and the horizontal burn rates were in the range of 40 to 50 mm/min. In examples 2, 5, 8 and 11, half of the DEGDB was replaced with RDP. In these examples, the horizontal burn rate decreased and the UL94 vertical burn test improved to a V2 rating. In examples 3, 6, 9 and 12, all of the DEGDB was replaced with RDP. In these examples, the UL94 test gave a V2 rating and the horizontal burn rate slowed significantly in comparison with examples containing less RDP.

Table 3
Flame Retardant Polyester Compositions
(White Opaque Formulations)

Example No.	1	2	3	4	5	6
Copolyester (wt%)	57.8	57.8	57.8	57.8	57.8	57.8
Montan wax release additive (wt%)	0.9	0.9	0.9	0.9	0.9	0.9
DEGDB (wt%)	15.3	7.65	0	15.3	7.65	0
TiO ₂ (wt%)	6	6	6	6	6	6
Carbon Black (wt%)						
CaCO ₃ (wt%)	20	20	20			
Kaolin (wt%)				20	20	20
RDP (wt%)		7.65	15.3		7.65	15.3
Vertical Burn Test Result (UL94)	Fail	V2	V2	Fail	V2	V2
Avg. Horiz. Burn Rate (FMVSS 302)	42	36	11	40	2	0
Tg °C of Polyester Composition	22	27	39	19	27	37

Table 4
Flame Retardant Polyester Compositions
(Black Opaque Formulations)

Example No.	7	8	9	10	11	12
Copolyester (wt%)	62.5	62.5	62.5	62.5	62.5	62.5
Montan wax release additive (wt%)	0.9	0.9	0.9	0.9	0.9	0.9
DEGDB (wt%)	15.6	7.8	0	15.6	7.8	0
TiO ₂ (wt%)						
Carbon Black (wt%)	1	1	1	1	1	1
CaCO ₃ (wt%)	20	20	20			
Kaolin (wt%)				20	20	20
RDP (wt%)		7.8	15.6		7.8	15.6
Vertical Burn Test Result (UL94)	Fail	V2	V2	Fail	V2	V2
Avg. Horiz. Burn Rate (FMVSS 302)	50	47	25	52	17	No data obtained
Tg °C	24	31	40	22	29	38

[0064] RDP also may be used to replace all or a portion of the plasticizer. The Tg of the materials increased as the DEGDB was replaced with RDP. The Tg of an un-plasticized formulation is 80°C. RDP can be used with both rigid and flexible formulations. RDP reduced Tg of the polyester composition but was less effective in comparison to DEGDB. In order to maintain the proper Tg of in a flexible formulation, additional DEGDB or other plasticizer typically will be required to be added back to the polyester composition. Table 5 shows the effect of the combination of DEGDB and RDP on the Tg of the polyester composition. The data of Table 5 is bracketed between a 1:1 replacement of DEGDB with RDP and the addition RDP to the formulation with no drop in the DEGDB level.

- 34 -

Table 5
Effect of DEGDB and RDP on Tg

Tg of Composition, °C						
DEGDB (wt%)	20	22	16	11	10	-3
	17.5		23			
	15		26	21		
	10			29	23	14
	5				36	
	0	80				38
		0	5	10	15	20
		RDP (wt%)				

[0065] The actual levels required to maintain a Tg of less than or equal to room temperature are approximately equal to replacing DEGDB with 2x RDP. The prophetic data of Table 6 shows the predicted level of DEGDB required at various RDP levels to maintain a room temperature Tg.

Table 6
Predicted Levels of RDP and DEGDB

RDP (wt%)	DEGDB (wt%)	Tg (°C)
0	20	22
5	17.5	23
10	15	21
15	10	23
20	6	20

[0066] *Examples 13-20.* Flame retardant polyester compositions were prepared using the general procedure described above but using various phosphate flame retardants at a concentration of 10 wt% based on the total weight of the polyester composition. Results are presented in Table 7.

- 35 -

Table 7

Example	Flame Retardant	Average Burn Rate	Tg °C
13	NCENDX [®] P-30 b (available from Albemarle Chemical Co.)	0	15
14	Tilauryl Phosphite	0	
15	Triphenyl Phosphate	0	-4
16	Reofos [®] 507 (Mixture of Triaryl Phosphates "TAP"; TAP tert butylated; Mono(t-butyl phenyl) diphenyl Phosphate, available from Great Lakes Chemical Co.)	0 (2 samples) 48 (1 sample)	6
17	Bisphenol-A Diphosphate	0	12
18	Trixylenyl Phosphate	0	4
19	Tricresyl Phosphate	0	-12
20	Isodecyl diphenyl Phosphate	87	-8

- 36 -

CLAIMS

We claim:

1. A flame retardant polyester composition for calendering, comprising:
 - (a) a polyester having a crystallization half time from a molten state of at least 5 minutes wherein said polyester is a random copolymer;
 - (b) a plasticizer;
 - (c) a phosphorus-containing flame retardant miscible with said polyester plasticized with said plasticizer; and
 - (d) an additive effective to prevent sticking of the polyester to calendering rolls.
2. The polyester composition of claim 1 wherein said plasticizer comprises one or more aromatic rings.
3. The polyester composition of claim 2 wherein said plasticizer comprises from 10 to 40 weight percent (wt%) of said polyester composition based on the total weight of said polyester composition.
4. The polyester composition of claim 3 wherein said plasticizer dissolves a 5-mil (.127 mm) thick film of said polyester to produce a clear solution at a temperature of 160°C or less.
5. The polyester composition of claim 4 wherein said plasticizer has a solubility parameter in the range of 9.5 to 13.0 $\text{cal}^{0.5}\text{cm}^{-1.5}$.
6. The polyester composition of 5 wherein said plasticizer is an ester comprising
 - (i) an acid residue comprising one or more of: phthalic acid, adipic acid, trimellitic acid, benzoic acid, azelaic acid, terephthalic acid, isophthalic acid, butyric acid, glutaric acid, citric acid or phosphoric acid; and

- 37 -

- (ii) an alcohol residue comprising one or more aliphatic, cycloaliphatic, or aromatic alcohols containing up to 20 carbon atoms.
7. The polyester composition of claim 6 wherein said alcohol residue of the plasticizer is methanol, ethanol, propanol, isopropanol, butanol, isobutanol, stearyl alcohol, lauryl alcohol, phenol, benzyl alcohol, hydroquinone, catechol, resorcinol, ethylene glycol, neopentyl glycol, 1,4-cyclohexanedimethanol, or diethylene glycol.
 8. The polyester composition of claim 7 wherein said crystallization half time of the polyester is at least 12 minutes.
 9. The polyester composition of claim 8 wherein said crystallization half time is at least 300 minutes.
 10. The polyester composition of claim 9 wherein said polyester comprises (i) at least 80 mole percent of diacid residues comprising one or more of: terephthalic acid, naphthalenedicarboxylic acid, 1,4-cyclohexanedicarboxylic acid, or isophthalic acid; and (ii) diol residues comprising 10 to 100 mole percent 1,4-cyclohexanedimethanol and 0 to 90 mole percent of one or more diols containing 2 to 20 carbon atoms, wherein said diacid residues are based on 100 mole percent and the diol residues are based on 100 mole percent.
 11. The polyester composition of claim 10 wherein said diol residues comprise one or more diols selected from ethylene glycol, 1,2-propanediol, 1,3-propanediol, propylene glycol, 1,4-butanediol, 1,5-pentanediol, neopentyl glycol, diethylene glycol, 1,6-hexanediol, 1,8-octanediol, 2,2,4-trimethyl-1,3-pentanediol, 2,2,4,4-tetramethyl-1,3-cyclobutanediol, 1,3-cyclohexanedimethanol, bisphenol A, and polyalkylene glycol.

- 38 -

12. The polyester composition of claim 11 wherein said diol residues comprise 10 to 100 mole percent 1,4-cyclohexanedimethanol and 0 to 90 mole percent ethylene glycol.
13. The polyester composition of claim 12 wherein said diacid residues further comprise 0 to 20 mole percent of one or more modifying diacids containing 4 to 40 carbon atoms.
14. The polyester composition of claim 13 wherein said modifying diacid comprises one or more of: succinic acid, glutaric acid, adipic acid, suberic acid, sebacic acid, azelaic acid, dimer acid, or sulfoisophthalic acid.
15. The polyester composition of claim 14 wherein said plasticizer comprises one or more benzoates, phthalates, phosphates, or isophthalates.
16. The polyester composition of claim 15 wherein said plasticizer comprises diethylene glycol dibenzoate.
17. The polyester composition of claim 16 wherein said flame retardant comprises 5 to 40 wt%, based on the total weight of said polyester composition, of one or more monoesters, diesters, or triesters of phosphoric acid.
18. The polyester composition of claim 17 wherein said flame retardant is a plasticizer for said polyester.
19. The polyester composition of claim 18 wherein said flame retardant comprises resorcinol bis(diphenyl phosphate).
20. The polyester composition of claim 19 wherein said polyester composition has a Tg of 30°C or less.

- 39 -

21. The polyester composition of claim 20 wherein said polyester composition has a Tg of 20°C or less.
22. A flame retardant polyester composition for calendering, comprising:
- (a) a polyester having a crystallization half time from a molten state of at least 10 minutes wherein said polyester is a random copolymer comprising (i) at least 80 mole percent of diacid residues comprising one or more of: terephthalic acid, naphthalenedicarboxylic acid, 1,4-cyclohexanedicarboxylic acid, or isophthalic acid; and (ii) diol residues comprising 20 to 40 mole percent 1,4-cyclohexanedimethanol and 60 to 80 mole percent of one or more diols containing 2 to 20 carbon atoms, wherein said diacid residues are based on 100 mole percent and the diol residues are based on 100 mole percent;
 - (b) 10 wt% to 40 wt% of plasticizer comprising one or more benzoates, phthalates, phosphates, or isophthalates;
 - (c) 5 wt% to 40 wt% of a phosphorus-containing flame retardant miscible with said polyester plasticized with said plasticizer; and
 - (d) an additive effective to prevent sticking of the polyester to calendering rolls, wherein said wt% is based upon the total weight of said polyester composition.
23. The polyester composition of claim 22 wherein said additive comprises 0.1 wt% to 10 wt%, based on the total weight of the polyester composition, of one or more fatty acid amides, metal salts of organic acids, fatty acids, fatty acid salts, fatty acid esters, hydrocarbon waxes, ester waxes, phosphoric acid esters, chemically modified polyolefin waxes; glycerin esters, talc, or acrylic copolymers.
24. The polyester composition of claim 23 wherein said additive comprises: erucylamide, stearamide, calcium stearate, zinc stearate, stearic acid, oleic acid, palmitic acid, paraffin wax, polyethylene waxes, polypropylene waxes, carnauba wax, glycerol monostearate, and glycerol distearate.

- 40 -

25. The polyester composition of claim 24 further comprising (e) an oxidative stabilizer.
26. The polyester resin composition of claim 25 further comprising (f) a melt strength enhancer.
27. The polyester composition of claim 23 wherein said additive comprises (i) a fatty acid or a salt of a fatty acid containing more than 18 carbon atoms and (ii) an ester wax comprising a fatty acid residue containing more than 18 carbon atoms with an alcohol residue containing 2 to 28 carbon atoms, wherein the ratio of said fatty acid or said salt of a fatty acid to said ester wax is 1:1 or greater.
28. The polyester composition of claim 27 wherein said additive is present from 0.1 to 2 weight percent.
29. The polyester composition of claim 28 wherein said fatty acid comprises montanic acid; said salt of a fatty acid comprises one or more of: the sodium salt of montanic acid, the calcium salt of montanic acid, or the lithium salt of montanic acid; and said fatty acid residue of said ester wax comprises montanic acid.
30. The polyester composition of claim 29 wherein said alcohol residue of said ester wax is comprises one or more of: montanyl alcohol, ethylene glycol, butylene glycol, glycerol or pentaerythritol.
31. The polyester composition of claim 30 wherein said ester wax has been partially saponified with calcium hydroxide.
32. The polyester composition of claim 31 wherein the ratio of said fatty acid or said salt of a fatty acid to said ester wax is 2:1 or greater.
33. A process for a flame retardant film or a sheet, comprising: calendering a polyester composition comprising

- 41 -

- (a) a polyester having a crystallization half time from a molten state of at least 5 minutes, wherein said polyester is a random copolymer;
 - (b) a plasticizer;
 - (c) a phosphorus-containing flame retardant miscible with said polyester plasticized with said plasticizer; and
 - (d) an additive effective to prevent sticking of the polyester to calendering rolls.
34. The process of claim 33 wherein said plasticizer comprises one or more aromatic rings.
35. The process of claim 34 wherein said plasticizer comprises 10 to 40 wt% of said polyester composition based on the total weight of said polyester composition.
36. The process of claim 35 wherein said plasticizer dissolves a 5-mil (.127 mm) thick film of said polyester to produce a clear solution at a temperature of 160°C or less.
37. The process of claim 36 wherein said plasticizer has a solubility parameter in the range of 9.5 to 13.0 cal^{0.5}cm^{-1.5}.
38. The process of 37 wherein said plasticizer is an ester comprising
- (i) an acid residue comprising one or more of: phthalic acid, adipic acid, trimellitic acid, benzoic acid, azelaic acid, terephthalic acid, isophthalic acid, butyric acid, glutaric acid, citric acid or phosphoric acid; and
 - (ii) an alcohol residue comprising one or more of: methanol, ethanol, propanol, isopropanol, butanol, isobutanol, stearyl alcohol, lauryl alcohol, phenol, benzyl alcohol, hydroquinone, catechol, resorcinol, ethylene glycol, neopentyl glycol, 1,4-cyclohexanedimethanol, or diethylene glycol.
39. The process of claim 38 wherein said polyester composition comprises a molten, pellet or powder form and is passed through a compressive nip between at least two calendering rolls at temperatures of 100°C to 200°C.

- 42 -

40. The process of claim 39 wherein said polyester has a crystallization half time of at least 300 minutes.
41. The process of claim 40 wherein said polyester comprises (i) at least 80 mole percent of diacid residues comprising one or more of: terephthalic acid, naphthalenedicarboxylic acid, 1,4-cyclohexanedicarboxylic acid, or isophthalic acid; and (ii) diol residues comprising 10 to 100 mole percent 1,4-cyclohexanedimethanol and 0 to 90 mole percent of one or more diols selected from ethylene glycol, 1,2-propanediol, 1,3-propanediol, propylene glycol, 1,4-butanediol, 1,5-pentanediol, neopentyl glycol, diethylene glycol, 1,6-hexanediol, 1,8-octanediol, 2,2,4-trimethyl-1,3-pentanediol, 2,2,4,4-tetramethyl-1,3-cyclobutanediol, 1,3-cyclohexanedimethanol, bisphenol A, and polyalkylene glycol, wherein said diacid residues are based on 100 mole percent and said diol residues are based on 100 mole percent.
42. The process of claim 41 wherein said diol residues comprise 10 to 100 mole percent 1,4-cyclohexanedimethanol and 0 to 90 mole percent ethylene glycol.
43. The polyester composition of claim 42 wherein said plasticizer comprises one or more benzoates, phthalates, phosphates, or isophthalates.
44. The polyester composition of claim 43 wherein said plasticizer comprises diethylene glycol dibenzoate.
45. The process of claim 44 wherein said flame retardant comprises 5 to 40 wt%, based on the total weight of said polyester composition, of one or more monoesters, diesters, or triesters of phosphoric acid.
46. The process of claim 45 wherein said flame retardant is a plasticizer for said polyester.

- 43 -

47. The process of claim 46 wherein said flame retardant comprises resorcinol bis(diphenyl phosphate).
48. The process of claim 47 wherein said polyester composition has a T_g of 30°C or less.
49. The process of claim 48 wherein said additive comprises 0.1 wt% to 10 wt%, based on the total weight of the polyester composition, of one or more fatty acid amides, metal salts of organic acids, fatty acids, fatty acid salts, fatty acid esters, hydrocarbon waxes, ester waxes, phosphoric acid esters, chemically modified polyolefin waxes; glycerin esters, talc, or acrylic copolymers.
50. The process of claim 49 wherein said additive comprises (i) a fatty acid or a salt of a fatty acid containing more than 18 carbon atoms and (ii) an ester wax comprising a fatty acid residue containing more than 18 carbon atoms and an alcohol residue containing 2 to 28 carbon atoms, wherein the ratio of said fatty acid or said salt of a fatty acid to said ester wax is 1:1 or greater.
51. The process of claim 50 wherein said fatty acid comprises montanic acid; said salt of a fatty acid comprises one or more of: the sodium salt of montanic acid, the calcium salt of montanic acid, or the lithium salt of montanic acid; and said fatty acid residue of said ester wax comprises montanic acid.
52. A flame retardant film or sheet comprising a polyester composition, said polyester composition comprising
- (a) a polyester having a crystallization half time from a molten state of at least, 5 minutes, wherein said polyester is a random copolymer;
 - (b) a plasticizer;
 - (c) an phosphorus-containing flame retardant miscible with said polyester plasticized with said plasticizer; and

- 44 -

- (d) an additive effective to prevent sticking of the polyester to calendering rolls, wherein said film or sheet is prepared by calendering said polyester composition.
53. The film or sheet of claim 52 wherein said plasticizer comprises one or more aromatic rings.
54. The film or sheet of claim 53 wherein said plasticizer comprises 10 to 40 wt% of said polyester composition based on the total weight of said polyester composition.
55. The film or sheet of claim 54 wherein said plasticizer dissolves a 5-mil (.127 mm) thick film of said polyester to produce a clear solution at a temperature of 160°C or less.
56. The film or sheet of claim 55 wherein said plasticizer has a solubility parameter in the range of 9.5 to 13.0 $\text{cal}^{0.5}\text{cm}^{-1.5}$.
57. The film or sheet of 56 wherein said plasticizer is an ester comprising
- (i) an acid residue comprising one or more of: phthalic acid, adipic acid, trimellitic acid, benzoic acid, azelaic acid, terephthalic acid, isophthalic acid, butyric acid, glutaric acid, citric acid or phosphoric acid; and
 - (ii) an alcohol residue comprising one or more of: methanol, ethanol, propanol, isopropanol, butanol, isobutanol, stearyl alcohol, lauryl alcohol, phenol, benzyl alcohol, hydroquinone, catechol, resorcinol, ethylene glycol, neopentyl glycol, 1,4-cyclohexanedimethanol, or diethylene glycol.
58. The film or sheet of claim 57 wherein said polyester has a crystallization half time of at least 300 minutes.
59. The film or sheet of claim 58 wherein said polyester comprises (i) at least 80 mole percent of diacid residues comprising one or more of: terephthalic acid, naphthalenedicarboxylic acid, 1,4-cyclohexanedicarboxylic acid, or isophthalic

- 45 -

acid; and (ii) diol residues comprising 10 to 100 mole percent 1,4-cyclohexanedimethanol and 0 to 90 mole percent of one or more diols selected from ethylene glycol, 1,2-propanediol, 1,3-propanediol, propylene glycol, 1,4-butanediol, 1,5-pentanediol, neopentyl glycol, diethylene glycol, 1,6-hexanediol, 1,8-octanediol, 2,2,4-trimethyl-1,3-pentanediol, 2,2,4,4-tetramethyl-1,3-cyclobutanediol, 1,3-cyclohexanedimethanol, bisphenol A, and polyalkylene glycol, wherein said diacid residues are based on 100 mole percent and said diol residues are based on 100 mole percent.

60. The film or sheet of claim 59 wherein said diol residues comprise 10 to 100 mole percent 1,4-cyclohexanedimethanol and 0 to 90 mole percent ethylene glycol.
61. The polyester composition of claim 60 wherein said plasticizer comprises one or more benzoates, phthalates, phosphates, or isophthalates.
62. The polyester composition of claim 61 wherein said plasticizer comprises diethylene glycol dibenzoate.
63. The film or sheet of claim 62 wherein said flame retardant comprises 5 to 40 wt%, based on the total weight of said polyester composition, of one or more monoesters, diesters, or triesters of phosphoric acid.
64. The film or sheet of claim 63 wherein said flame retardant is a plasticizer for said polyester.
65. The film or sheet of claim 64 wherein said flame retardant comprises resorcinol bis(diphenyl phosphate).
66. The film or sheet of claim 65 wherein said polyester composition has a Tg of 30°C or less.

- 46 -

67. The film or sheet of claim 66 wherein said additive 0.1 wt% to 10 wt%, based on the total weight of the polyester composition, of one or more fatty acid amides, metal salts of organic acids, fatty acids, fatty acid salts, fatty acid esters, hydrocarbon waxes, ester waxes, phosphoric acid esters, chemically modified polyolefin waxes; glycerin esters, talc, or acrylic copolymers.
68. The film or sheet of claim 67 wherein said additive comprises (i) a fatty acid or a salt of a fatty acid containing more than 18 carbon atoms and (ii) an ester wax comprising a fatty acid residue containing more than 18 carbon atoms and an alcohol residue containing 2 to 28 carbon atoms, wherein the ratio of said fatty acid or said salt of a fatty acid to said ester wax is 1:1 or greater.
69. The film or sheet of claim 68 wherein said fatty acid comprises montanic acid; said salt of a fatty acid comprises one or more of: the sodium salt of montanic acid, the calcium salt of montanic acid, or the lithium salt of montanic acid; and said fatty acid residue of said ester wax comprises montanic acid.
70. A flame retardant polyester composition for calendering, comprising:
- (a) 50 to 95 weight percent of a polyester having a melting temperature of less than 220°C and exhibiting more than 1 percent crystallinity after annealing for 2000 minutes at a temperature at which said polyester has a maximum crystallization rate, wherein said polyester is a random copolymer;
 - (b) 5 to 50 wt% of a plasticizer miscible with said polyester, based on the total weight of said polyester composition; and
 - (c) a phosphorus-containing flame retardant miscible with said polyester plasticized with said plasticizer.
71. The polyester composition of claim 70 wherein said plasticizer comprises one or more aromatic rings.
72. The polyester composition of claim 71 further comprising (d) an additive effective to prevent sticking of the polyester to the calender rolls.

73. The polyester composition of claim 72 wherein said plasticizer comprises 10 to 40 wt% of said polyester composition based on the total weight of said polyester composition.
74. The polyester composition of claim 73 wherein said plasticizer dissolves a 5-mil (.127 mm) thick film of said polyester to produce a clear solution at a temperature of 160°C or less.
75. The polyester composition of claim 74 wherein said plasticizer has a solubility parameter in the range of 9.5 to 13.0 $\text{cal}^{0.5}\text{cm}^{-1.5}$.
76. The polyester composition of 75 wherein said plasticizer is an ester comprising
- (i) an acid residue comprising one or more of: phthalic acid, adipic acid, trimellitic acid, benzoic acid, azelaic acid, terephthalic acid, isophthalic acid, butyric acid, glutaric acid, citric acid or phosphoric acid; and
 - (ii) an alcohol residue comprising one or more of: methanol, ethanol, propanol, isopropanol, butanol, isobutanol, stearyl alcohol, lauryl alcohol, phenol, benzyl alcohol, hydroquinone, catechol, resorcinol, ethylene glycol, neopentyl glycol, 1,4-cyclohexanedimethanol, or diethylene glycol.
77. The polyester composition of claim 76 wherein said polyester comprises (i) at least 80 mole percent of diacid residues comprising one or more of: terephthalic acid, naphthalenedicarboxylic acid, 1,4-cyclohexanedicarboxylic acid, or isophthalic acid; and (ii) diol residues comprising 10 to 100 mole percent 1,4-cyclohexanedimethanol and 0 to 90 mole percent of one or more diols selected from ethylene glycol, 1,2-propanediol, 1,3-propanediol, propylene glycol, 1,4-butanediol, 1,5-pentanediol, neopentyl glycol, diethylene glycol, 1,6-hexanediol, 1,8-octanediol, 2,2,4-trimethyl-1,3-pentanediol, 2,2,4,4-tetramethyl-1,3-cyclobutanediol, 1,3-cyclohexanedimethanol, bisphenol A, and polyalkylene glycol, wherein said diacid residues are based on 100 mole percent and said diol residues are based on 100 mole percent.

78. The polyester composition of claim 77 wherein said diol residues comprise 10 to 100 mole percent 1,4-cyclohexanedimethanol and 0 to 90 mole percent ethylene glycol.
79. The polyester composition of claim 78 wherein said plasticizer comprises one or more benzoates, phthalates, phosphates, or isophthalates.
80. The polyester composition of claim 79 wherein said plasticizer comprises diethylene glycol dibenzoate.
81. The polyester composition of claim 80 wherein said flame retardant comprises 5 to 40 wt%, based on the total weight of said polyester composition, of one or more monoesters, diesters, or triesters of phosphoric acid.
82. The polyester composition of claim 81 wherein said flame retardant is a plasticizer for said polyester.
83. The polyester composition of claim 82 wherein said flame retardant comprises resorcinol bis(diphenyl phosphate).
84. The polyester composition of claim 83 wherein said polyester composition has a T_g of 30°C or less.
85. A process for a flame retardant film or a sheet, comprising:
 - (i) calendering a polyester composition comprising
 - (a) 50 to 95 weight percent of a polyester having a melting temperature of less than 220°C and exhibiting more than 1 percent crystallinity after annealing for 2000 minutes at a temperature at which said polyester has a maximum crystallization rate, wherein said polyester is a random copolymer;

- 49 -

- (b) 5 to 50 wt% of a plasticizer miscible with said polyester, based on the total weight of said polyester composition; and
 - (c) a phosphorus-containing flame retardant miscible with said polyester plasticized with said plasticizer; and
 - (ii) inducing crystallization during step (i) or after step (i).
86. The process of claim 85 wherein said plasticizer comprises one or more aromatic rings.
87. The process of claim 86 wherein said plasticizer comprises 10 to 40 wt% of said polyester composition based on the total weight of said polyester composition.
88. The process of claim 87 wherein said plasticizer dissolves a 5-mil (.127 mm) thick film of said polyester to produce a clear solution at a temperature of 160°C or less.
89. The process of claim 88 wherein said plasticizer has a solubility parameter in the range of 9.5 to 13.0 $\text{cal}^{0.5}\text{cm}^{-1.5}$.
90. The process of 89 wherein said plasticizer is an ester comprising
- (i) an acid residue comprising one or more of: phthalic acid, adipic acid, trimellitic acid, benzoic acid, azelaic acid, terephthalic acid, isophthalic acid, butyric acid, glutaric acid, citric acid or phosphoric acid; and
 - (ii) an alcohol residue comprising one or more of methanol, ethanol, propanol, isopropanol, butanol, isobutanol, stearyl alcohol, lauryl alcohol, phenol, benzyl alcohol, hydroquinone, catechol, resorcinol, ethylene glycol, neopentyl glycol, 1,4-cyclohexanedimethanol, or diethylene glycol.
91. The process of claim 90 wherein said polyester comprises (i) at least 80 mole percent of diacid residues comprising one or more of: terephthalic acid, naphthalenedicarboxylic acid, 1,4-cyclohexanedicarboxylic acid, or isophthalic acid; and (ii) diol residues comprising 10 to 100 mole percent 1,4-cyclohexanedimethanol and 0 to 90 mole percent of one or more diols selected

- 50 -

from ethylene glycol, 1,2-propanediol, 1,3-propanediol, propylene glycol, 1,4-butanediol, 1,5-pentanediol, neopentyl glycol, diethylene glycol, 1,6-hexanediol, 1,8-octanediol, 2,2,4-trimethyl-1,3-pentanediol, 2,2,4,4-tetramethyl-1,3-cyclobutanediol, 1,3-cyclohexanedimethanol, bisphenol A, and polyalkylene glycol, wherein said diacid residues are based on 100 mole percent and said diol residues are based on 100 mole percent.

92. The process of claim 91 wherein said diol residues comprise 10 to 100 mole percent 1,4-cyclohexanedimethanol and 0 to 90 mole percent ethylene glycol.
93. The polyester composition of claim 92 wherein said plasticizer comprises one or more benzoates, phthalates, phosphates, or isophthalates.
94. The polyester composition of claim 93 wherein said plasticizer comprises diethylene glycol dibenzoate.
95. The process of claim 94 wherein said flame retardant comprises 5 to 40 wt%, based on the total weight of said polyester composition, of one or more monoesters, diesters, or triesters of phosphoric acid.
96. The process of claim 95 wherein said flame retardant is a plasticizer for said polyester.
97. The process of claim 96 wherein said flame retardant comprises resorcinol bis(diphenyl phosphate).
98. The process of claim 97 wherein said polyester composition has a Tg of 30°C or less.
99. The process of claim 98 wherein said polyester composition comprises a molten, pellet or powder form and is passed through a compressive nip between at least two calendering rolls at temperatures of 100°C to 200°C.

100. A flame retardant film or sheet, comprising:
- (a) 50 to 95 weight percent of a polyester having a melting temperature of less than 220°C and exhibiting more than 1 percent crystallinity after annealing for 2000 minutes at a temperature at which said polyester has a maximum crystallization rate, wherein said polyester is a random copolymer;
 - (b) 5 to 50 weight percent of a plasticizer miscible with said polyester; and
 - (c) a phosphorus-containing flame retardant miscible with said polyester plasticized with said plasticizer.
101. The film or sheet of claim 100 wherein said plasticizer comprises one or more aromatic rings.
102. The film or sheet of claim 101 wherein said plasticizer comprises 10 to 40 wt% of said polyester composition based on the total weight of said polyester composition.
103. The film or sheet of claim 102 wherein said plasticizer dissolves a 5-mil (.127 mm) thick film of said polyester to produce a clear solution at a temperature of 160°C or less.
104. The film or sheet of claim 103 wherein said plasticizer has a solubility parameter in the range of 9.5 to 13.0 cal^{0.5}cm^{-1.5}.
105. The film or sheet of 104 wherein said plasticizer is an ester comprising
- (i) an acid residue comprising one or more of: phthalic acid, adipic acid, trimellitic acid, benzoic acid, azelaic acid, terephthalic acid, isophthalic acid, butyric acid, glutaric acid, citric acid or phosphoric acid; and
 - (ii) an alcohol residue comprising one or more of methanol, ethanol, propanol, isopropanol, butanol, isobutanol, stearyl alcohol, lauryl alcohol, phenol, benzyl alcohol, hydroquinone, catechol, resorcinol, ethylene glycol, neopentyl glycol, 1,4-cyclohexanedimethanol, or diethylene glycol.

- 52 -

106. The film or sheet of claim 105 wherein said polyester comprises (i) at least 80 mole percent of diacid residues comprising one or more of: terephthalic acid, naphthalenedicarboxylic acid, 1,4-cyclohexanedicarboxylic acid, or isophthalic acid; and (ii) diol residues comprising 10 to 100 mole percent 1,4-cyclohexanedimethanol and 0 to 90 mole percent of one or more diols selected from ethylene glycol, 1,2-propanediol, 1,3-propanediol, propylene glycol, 1,4-butanediol, 1,5-pentanediol, neopentyl glycol, diethylene glycol, 1,6-hexanediol, 1,8-octanediol, 2,2,4-trimethyl-1,3-pentanediol, 2,2,4,4-tetramethyl-1,3-cyclobutanediol, 1,3-cyclohexanedimethanol, bisphenol A, and polyalkylene glycol, wherein said diacid residues are based on 100 mole percent and said diol residues are based on 100 mole percent.
107. The film or sheet of claim 106 wherein said diol residues comprise 10 to 100 mole percent 1,4-cyclohexanedimethanol and 0 to 90 mole percent ethylene glycol.
108. The polyester composition of claim 107 wherein said plasticizer comprises one or more benzoates, phthalates, phosphates, or isophthalates.
109. The polyester composition of claim 108 wherein said plasticizer comprises diethylene glycol dibenzoate.
110. The film or sheet of claim 109 wherein said flame retardant comprises 5 to 40 wt%, based on the total weight of said polyester composition, of one or more monoesters, diesters, or triesters of phosphoric acid.
111. The film or sheet of claim 110 wherein said flame retardant is a plasticizer for said polyester.
112. The film or sheet of claim 111 wherein said flame retardant comprises resorcinol bis(diphenyl phosphate).

- 53 -

113. The film or sheet of claim 112 wherein said polyester composition has a Tg of 30°C or less.

(19) World Intellectual Property
Organization
International Bureau



(43) International Publication Date
22 July 2004 (22.07.2004)

PCT

(10) International Publication Number
WO 2004/060990 A3

- (51) International Patent Classification⁷: **C08K 5/00**
- (21) International Application Number:
PCT/US2003/039314
- (22) International Filing Date:
10 December 2003 (10.12.2003)
- (25) Filing Language: English
- (26) Publication Language: English
- (30) Priority Data:
60/435,584 20 December 2002 (20.12.2002) US
10/706,669 12 November 2003 (12.11.2003) US
- (71) Applicant: **EASTMAN CHEMICAL COMPANY**
[US/US]; 100 North Eastman Road, Kingsport, TN 37660 (US).
- (72) Inventors: **STRAND, Marc, Alan**; 5123 Waterford Drive, Kingsport, TN 37664 (US). **PINER, Rodney, Layne**; 212 Hidden Acres Road, Kingsport, TN 37664 (US).
- (74) Agent: **MIDDLEMAS, Eric, D.**; P.O. Box 511, Kingsport, TN 37662-5075 (US).
- (81) Designated States (*national*): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BW, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NI, NO, NZ, OM, PG, PH, PL, PT, RO, RU, SC, SD, SE, SG, SK, SL, SY, TJ, TM, TN, TR, TT, TZ, UA, UG, UZ, VC, VN, YU, ZA, ZM, ZW.
- (84) Designated States (*regional*): ARIPO patent (BW, GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HU, IE, IT, LU, MC, NL, PT, RO, SE, SI, SK, TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).
- Published:
— with international search report
— before the expiration of the time limit for amending the claims and to be republished in the event of receipt of amendments
- (88) Date of publication of the international search report:
4 November 2004
- For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.*

(54) Title: **FLAME RETARDANT POLYESTER COMPOSITIONS FOR CALENDERING**

(57) Abstract: Flame retardant polyester compositions suitable for calendering may be prepared from polyesters having crystallization half time of at least 5 minutes, a plasticizer, a phosphorus-containing flame retardant miscible with the plasticized polyester, and an additive effective to prevent sticking of the polyester to the calendar rolls. Also disclosed are processes for flame retardant films or sheets by calendering the above compositions and the flame retardant films or sheets produced therefrom. These films and sheets have excellent appearance, flexibility, and flame retardancy, and can be used in a wide range of decorative and packaging applications.

WO 2004/060990 A3

INTERNATIONAL SEARCH REPORT

International Application No.

PCT/US 03/39314

A. CLASSIFICATION OF SUBJECT MATTER
IPC 7 C08K5/00

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 C08K

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EPO-Internal, WPI Data, PAJ

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	WO 99/47605 A (EASTMAN CHEM CO) 23 September 1999 (1999-09-23) cited in the application page 1, line 27 - page 2, line 1 page 3, paragraph 1 page 6, paragraph 3 page 7, paragraph 2 page 7, paragraph 4 page 10, paragraph 2 examples; tables	1-69
A	WO 02/068513 A (EASTMAN CHEM CO) 6 September 2002 (2002-09-06) claims; examples; tables ----- -/-	1,8,10, 22,23, 27-29

☒ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

* Special categories of cited documents:

- *A* document defining the general state of the art which is not considered to be of particular relevance
- *E* earlier document but published on or after the international filing date
- *L* document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- *O* document referring to an oral disclosure, use, exhibition or other means
- *P* document published prior to the international filing date but later than the priority date claimed

- *T* later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
- *X* document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
- *Y* document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.
- *Z* document member of the same patent family

Date of the actual completion of the international search

30 August 2004

Date of mailing of the international search report

02. 09. 2004

Name and mailing address of the ISA

European Patent Office, P.B. 5818 Patentlaan 2
NL - 2280 HV Rijswijk
Tel. (+31-70) 340-2040, Tx. 31 651 epo nl,
Fax: (+31-70) 340-3016

Authorized officer

Engel, S

INTERNATIONAL SEARCH REPORT

International Application No.

PCT/US 03/39314

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	WO 02/083769 A (EASTMAN CHEM CO) 24 October 2002 (2002-10-24) claims; examples; tables -----	70-113
Y	PATENT ABSTRACTS OF JAPAN vol. 2002, no. 08, 5 August 2002 (2002-08-05) & JP 2002 121362 A (ACHILLES CORP), 23 April 2002 (2002-04-23) abstract -----	70-113

INTERNATIONAL SEARCH REPORT

International application No.
PCT/US 03/39314

Box I Observations where certain claims were found unsearchable (Continuation of item 1 of first sheet)

This International Search Report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1. ☐ Claims Nos.:
because they relate to subject matter not required to be searched by this Authority, namely:
2. ☐ Claims Nos.:
because they relate to parts of the International Application that do not comply with the prescribed requirements to such an extent that no meaningful International Search can be carried out, specifically:
3. ☐ Claims Nos.:
because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

Box II Observations where unity of invention is lacking (Continuation of item 2 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:

see additional sheet

1. ☒ As all required additional search fees were timely paid by the applicant, this International Search Report covers all searchable claims.
2. ☐ As all searchable claims could be searched without effort justifying an additional fee, this Authority did not invite payment of any additional fee.
3. ☐ As only some of the required additional search fees were timely paid by the applicant, this International Search Report covers only those claims for which fees were paid, specifically claims Nos.:
4. ☐ No required additional search fees were timely paid by the applicant. Consequently, this International Search Report is restricted to the invention first mentioned in the claims; it is covered by claims Nos.:

Remark on Protest

- ☐ The additional search fees were accompanied by the applicant's protest.
- ☒ No protest accompanied the payment of additional search fees.

FURTHER INFORMATION CONTINUED FROM PCT/ISA/ 210

This International Searching Authority found multiple (groups of) inventions in this international application, as follows:

1. claims: 1-69

Composition, process and film comprising: polyester, having $T_1/2(\text{cryst.}) > 5 \text{ min.}$, plasticiser, P-containing flame retardant, anti-sticking agent.

2. claims: 70-113

Composition, process and film, comprising: polyester, having $T_m < 220^\circ\text{C}$ and crystallinity of $>1\%$ after annealing for 2000 min, plasticiser and P-containing flame retardant.

INTERNATIONAL SEARCH REPORT

Information on patent family members

International Application No

PCT/US 03/39314

Patent document cited in search report		Publication date	Patent family member(s)	Publication date
WO 9947605	A	23-09-1999	US 6068910 A	30-05-2000
			BR 9908841 A	12-12-2000
			CN 1293696 T	02-05-2001
			DE 69912108 D1	20-11-2003
			DE 69912108 T2	26-08-2004
			EP 1066339 A1	10-01-2001
			JP 3280374 B2	13-05-2002
			JP 2002506909 T	05-03-2002
			WO 9947605 A1	23-09-1999
			US 6551699 B1	22-04-2003
WO 02068513	A	06-09-2002	US 2002188092 A1	12-12-2002
			BR 0207418 A	10-08-2004
			EP 1392764 A1	03-03-2004
			JP 2004519539 T	02-07-2004
			WO 02068513 A1	06-09-2002
WO 02083769	A	24-10-2002	US 2003060546 A1	27-03-2003
			BR 0208598 A	10-08-2004
			EP 1379576 A1	14-01-2004
			WO 02083769 A1	24-10-2002
JP 2002121362	A	23-04-2002	NONE	

(19) World Intellectual Property
Organization
International Bureau



(43) International Publication Date
22 July 2004 (22.07.2004)

PCT

(10) International Publication Number
WO 2004/060990 A3

- (51) International Patent Classification⁷: **C08K 5/00**
- (21) International Application Number:
PCT/US2003/039314
- (22) International Filing Date:
10 December 2003 (10.12.2003)
- (25) Filing Language: English
- (26) Publication Language: English
- (30) Priority Data:
60/435,584 20 December 2002 (20.12.2002) US
10/706,669 12 November 2003 (12.11.2003) US
- (71) Applicant: **EASTMAN CHEMICAL COMPANY**
[US/US]; 100 North Eastman Road, Kingsport, TN 37660 (US).
- (72) Inventors: **STRAND, Marc, Alan**; 5123 Waterford Drive, Kingsport, TN 37664 (US). **PINER, Rodney, Layne**; 212 Hidden Acres Road, Kingsport, TN 37664 (US).
- (74) Agent: **MIDDLEMAS, Eric, D.**; P.O. Box 511, Kingsport, TN 37662-5075 (US).
- (81) Designated States (*national*): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BW, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NI, NO, NZ, OM, PG, PH, PL, PT, RO, RU, SC, SD, SE, SG, SK, SL, SY, TJ, TM, TN, TR, TT, TZ, UA, UG, UZ, VC, VN, YU, ZA, ZM, ZW.
- (84) Designated States (*regional*): ARIPO patent (BW, GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HU, IE, IT, LU, MC, NL, PT, RO, SE, SI, SK, TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).
- Published:
— with international search report
— with amended claims
- (88) Date of publication of the international search report:
4 November 2004
- Date of publication of the amended claims: 6 January 2005
- For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

(54) Title: FLAME RETARDANT POLYESTER COMPOSITIONS FOR CALENDERING

(57) Abstract: Flame retardant polyester compositions suitable for calendering may be prepared from polyesters having crystallization half time of at least 5 minutes, a plasticizer, a phosphorus-containing flame retardant miscible with the plasticized polyester, and an additive effective to prevent sticking of the polyester to the calendar rolls. Also disclosed are processes for flame retardant films or sheets by calendering the above compositions and the flame retardant films or sheets produced therefrom. These films and sheets have excellent appearance, flexibility, and flame retardancy, and can be used in a wide range of decorative and packaging applications.

WO 2004/060990 A3

AMENDED CLAIMS

received by the International Bureau on 19 October 2004 : claims 1-113 replaced by claims 1-33.

We claim:

1. A flame retardant polyester composition for calendering, comprising:
 - (a) a polyester having a crystallization half time from a molten state of at least 5 minutes wherein said polyester is a random copolymer;
 - (b) a plasticizer;
 - (c) a phosphorus-containing flame retardant miscible with said polyester plasticized with said plasticizer; and
 - (d) an additive effective to prevent sticking of the polyester to calendering rolls.
2. The polyester composition of claim 1 wherein said plasticizer comprises one or more aromatic rings, is from 10 to 40 weight percent (wt%) of said polyester composition, based on the total weight of said polyester composition, and dissolves a 5-mil (.127 mm) thick film of said polyester to produce a clear solution at a temperature of 160°C or less.
3. The polyester composition of claim 2 wherein said plasticizer has a solubility parameter in the range of 9.5 to 13.0 cal^{0.5}cm^{-1.5}
4. The polyester composition of 3 wherein said plasticizer is an ester comprising
 - (i) an acid residue comprising one or more of: phthalic acid, adipic acid, trimellitic acid, benzoic acid, azelaic acid, terephthalic acid, isophthalic acid, butyric acid, glutaric acid, citric acid or phosphoric acid; and
 - (ii) an alcohol residue comprising one or more of: methanol, ethanol, propanol, isopropanol, butanol, isobutanol, stearyl alcohol, lauryl alcohol, phenol; benzyl alcohol, hydroquinone, catechol, resorcinol, ethylene glycol, neopentyl glycol, 1,4-cyclohexanedimethanol, or diethylene glycol.

5. The polyester composition of claim 4 wherein said crystallization half time of the polyester is at least 12 minutes.
6. The polyester composition of claim 5 wherein said polyester comprises (i) at least 80 mole percent of diacid residues comprising one or more of: terephthalic acid, naphthalenedicarboxylic acid, 1,4-cyclohexanedicarboxylic acid, or isophthalic acid; and (ii) diol residues comprising 10 to 100 mole percent 1,4-cyclohexanedimethanol and 0 to 90 mole percent of one or more diols selected from ethylene glycol, 1,2-propanediol, 1,3-propanediol, 1,4-butanediol, 1,5-pentanediol, neopentyl glycol, diethylene glycol, 1,6-hexanediol, 1,8-octanediol, 2,2,4-trimethyl-1,3-pentanediol, 2,2,4,4-tetramethyl-1,3-cyclobutanediol, 1,3-cyclohexanedimethanol, bisphenol A, and polyalkylene glycol.
7. The polyester composition of claim 6 wherein said diol residues comprise 10 to 100 mole percent 1,4-cyclohexanedimethanol and 0 to 90 mole percent ethylene glycol.
8. The polyester composition of claim 6 wherein said diacid residues further comprise 0 to 20 mole percent of one or more modifying diacids comprising one or more of: succinic acid, glutaric acid, adipic acid, suberic acid, sebacic acid, azelaic acid, dimer acid, or sulfoisophthalic acid; and said plasticizer comprises one or more benzoates, phthalates, phosphates, or isophthalates.
9. The polyester composition of claim 8 wherein said plasticizer comprises diethylene glycol dibenzoate.
10. The polyester composition of claim 8 wherein said flame retardant comprises 5 to 40 wt%, based on the total weight of said polyester composition, of one or more monoesters, diesters, or triesters of phosphoric acid.
11. The polyester composition of claim 10 wherein said flame retardant comprises resorcinol bis(diphenyl phosphate).

12. The polyester composition of claim 10 wherein said polyester composition has a Tg of 30°C or less.
13. The polyester composition of claim 1 wherein said crystallization half time from a molten state is at least 10 minutes; said polyester comprises (i) at least 80 mole percent of diacid residues comprising one or more of: terephthalic acid, naphthalenedicarboxylic acid, 1,4-cyclohexanedicarboxylic acid, or isophthalic acid; and (ii) diol residues comprising 20 to 40 mole percent 1,4-cyclohexanedimethanol and 60 to 80 mole percent of one or more diols containing 2 to 20 carbon atoms, wherein said diacid residues are based on 100 mole percent and the diol residues are based on 100 mole percent; and wherein said polyester composition comprises 10 wt% to 40 wt% of plasticizer comprising one or more benzoates, phthalates, phosphates, or isophthalates; 5 wt% to 40 wt% of a phosphorus-containing flame retardant miscible with said polyester plasticized with said plasticizer; and an additive effective to prevent sticking of the polyester to calendering rolls, wherein said wt% is based upon the total weight of said polyester composition.
14. The polyester composition of claim 13 wherein said additive comprises 0.1 wt% to 10 wt%, based on the total weight of the polyester composition, of one or more fatty acid amides, metal salts of organic acids, fatty acids, fatty acid salts, fatty acid esters, hydrocarbon waxes, ester waxes, phosphoric acid esters, chemically modified polyolefin waxes; glycerin esters, talc, or acrylic copolymers.
15. The polyester composition of claim 14 wherein said additive comprises erucylamide, stearamide, calcium stearate, zinc stearate, stearic acid, oleic acid, palmitic acid, paraffin wax, polyethylene waxes, polypropylene waxes, carnauba wax, glycerol monostearate, and glycerol distearate.
16. The polyester composition of claim 14 wherein said additive comprises (i) a fatty acid or a salt of a fatty acid containing more than 18 carbon atoms and (ii) an ester

wax comprising a fatty acid residue containing more than 18 carbon atoms with an alcohol residue containing 2 to 28 carbon atoms, wherein the ratio of said fatty acid or said salt of a fatty acid to said ester wax is 1:1 or greater.

17. The polyester composition of claim 16 wherein said fatty acid comprises montanic acid; said salt of a fatty acid comprises one or more of: the sodium salt of montanic acid, the calcium salt of montanic acid, or the lithium salt of montanic acid; said fatty acid residue of said ester wax comprises montanic acid; and said alcohol residue of said ester wax is comprises one or more of: montanyl alcohol, ethylene glycol, butylene glycol, glycerol or pentaerythritol.
18. The polyester composition of claim 17 wherein said ester wax has been partially saponified with calcium hydroxide.
19. The polyester composition of claim 18 wherein the ratio of said fatty acid or said salt of a fatty acid to said ester wax is 2:1 or greater.
20. A process for a flame retardant film or a sheet, comprising calendering the polyester composition of any one of claims 1-19.
21. A flame retardant film or sheet comprising a polyester composition of any one of claims 1-19.
22. A flame retardant polyester composition for calendering, comprising:
 - (a) 50 to 95 weight percent of a polyester having a melting temperature of less than 220°C and exhibiting more than 1 percent crystallinity after annealing for 2000 minutes at a temperature at which said polyester has a maximum crystallization rate, wherein said polyester is a random copolymer;
 - (b) 5 to 50 wt% of a plasticizer miscible with said polyester, based on the total weight of said polyester composition; and
 - (c) a phosphorus-containing flame retardant miscible with said polyester plasticized with said plasticizer.

23. The polyester composition of claim 22 further comprising (d) an additive effective to prevent sticking of the polyester to the calender rolls.
24. The polyester composition of claim 23 wherein said plasticizer comprises one or more aromatic rings; is 10 to 40 wt% of said polyester composition, based on the total weight of said polyester composition; and dissolves a 5-mil (.127 mm) thick film of said polyester to produce a clear solution at a temperature of 160°C or less.
25. The polyester composition of claim 24 wherein said plasticizer has a solubility parameter in the range of 9.5 to 13.0 cal^{0.5}cm^{-1.5}.
26. The polyester composition of 25 wherein said plasticizer is an ester comprising
- (i) an acid residue comprising one or more of: phthalic acid, adipic acid, trimellitic acid, benzoic acid, azelaic acid, terephthalic acid, isophthalic acid, butyric acid, glutaric acid, citric acid or phosphoric acid; and
 - (ii) an alcohol residue comprising one or more of: methanol, ethanol, propanol, isopropanol, butanol, isobutanol, stearyl alcohol, lauryl alcohol, phenol, benzyl alcohol, hydroquinone, catechol, resorcinol, ethylene glycol, neopentyl glycol, 1,4-cyclohexanedimethanol, or diethylene glycol.
27. The polyester composition of claim 26 wherein said polyester comprises (i) at least 80 mole percent of diacid residues comprising one or more of: terephthalic acid, naphthalenedicarboxylic acid, 1,4-cyclohexanedicarboxylic acid, or isophthalic acid; and (ii) diol residues comprising 10 to 100 mole percent 1,4-cyclohexanedimethanol and 0 to 90 mole percent of one or more diols selected from ethylene glycol, 1,2-propanediol, 1,3-propanediol, propylene glycol, 1,4-butanediol, 1,5-pentanediol, neopentyl glycol, diethylene glycol, 1,6-hexanediol, 1,8-octanediol, 2,2,4-trimethyl-1,3-pentanediol, 2,2,4,4-tetramethyl-1,3-cyclobutanediol, 1,3-cyclohexanedimethanol, bisphenol A, and polyalkylene glycol, wherein said diacid residues are based on 100 mole percent and said diol residues are based on 100 mole percent.

28. The polyester composition of claim 27 wherein said plasticizer comprises diethylene glycol dibenzoate.
29. The polyester composition of claim 28 wherein said flame retardant comprises 5 to 40 wt%, based on the total weight of said polyester composition, of one or more monoesters, diesters, or triesters of phosphoric acid.
30. The polyester composition of claim 29 wherein said flame retardant comprises resorcinol bis(diphenyl phosphate).
31. The polyester composition of claim 30 wherein said polyester composition has a Tg of 30°C or less.
32. A process for a flame retardant film or a sheet, comprising (i) calendering the polyester composition of any one of claims 22- 31; and (ii) inducing crystallization during step (i) or after step (i).
33. A flame retardant film or sheet, comprising the polyester composition of any one of claims 22-31.

THIS PAGE BLANK (USPTO)